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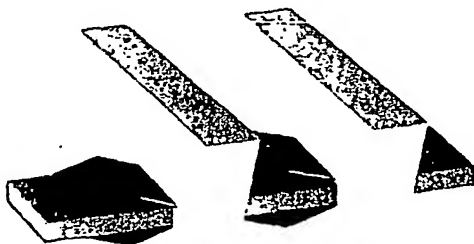
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(54) Title: PULLING V-BELT



like means being incorporated in the belt with radial overlapping end parts.

(57) Abstract: The invention relates to a drive belt for rotational transfer of a force between two or more drive wheels, provided with a tensile means for transferring the force to be transferred between said drive wheels, and a contact body for realising contact between the belt and the drive wheels, the contact body being composed of a plurality of transverse elements, and between which transverse elements, as taken in the longitudinal direction of the belt, in adhesive contact with the tensile means, is provided an intermediate body of a relatively soft elastically deformable material. The tensile means comprises a strap like means of minimal thickness, the width of which strap like means substantially corresponding to the width of the contacting body at the level of the tensile means in the belt, and the strap

PULLING V-BELT

The present invention relates to a pull type belt as defined in the preamble of claim 1.

5 Such belts are generally known in the art, either for application in fixed ratio, or for variable ratio transmissions. Such so called V-belts, simply called "rubber belts", have since long essentially been produced with a body of a natural or synthetic rubber material, and have a reinforcing tensile means in the form of a layer of a plurality of tensile elements such as cords, e.g. produced in a synthetic fibre. Commonly the
10 cords are incorporated in one layer, with the cords lying side by side. The tensile means is embedded in a rubber material. Within the layer, sometimes denoted cushion layer, commonly a specific type of rubber is applied for optimising the bounding between rubber and tensile element.

One limitation of this known type of belt is that the amount of transmissible
15 power, to be transferred from one pulley to another, by a wedging, i.e. clamping action of the sheaves of a pulley, is limited by the amount of power that can be transferred from the rubber to the tensile means. Thus, the force transferable from one pulley to the other is limited by the maximum load of the connection between the rubber and the cords within the belt.

20 Another and major drawback of the known V-belt concerns the smallest running diameter that can be attained at a virtually infinite time of operation of the belt. This phenomenon is especially relevant at V-belts for application in variable ratio transmissions. In these applications it is important to have a sufficiently lateral bearing or contacting surface for contacting the sheaves of a pulley, so as to guarantee a
25 proper and smooth shifting and running feature of the belt. However, this requirement increases the radial height of the conventional V-belt and therewith the bending stress in the belt. Bending stress occurs in a high extend at the radial outer side of a belt. Probably for this reason, the tensile elements of the known, i.e. conventional rubber belt are located closest possible to the radial outer surface of belt. The bending stress
30 also affects the connection between the body and the tensile elements, which connection plays an important role because of a requirement to have a sufficiently large surface area on the tensile elements for bonding, i.e. adhering these to the body material of the belt. The bonding should be such that a meaningful amount of force can be transmitted still during e.g. an industrially meaning full period of operation time
35 of the belt.

One solution for reducing internal bending stress commonly applied in commercialised belts is to provide laterally extending, generally V-shaped openings at the radial interior side of the belt. In this way the bending height of the belt is reduced with the radial depth of the openings. Still a relatively high pulley contacting face may be maintained at the rubber bodies between these grooves. Consequently, the bending stress is reduced proportionally with the depth of the groove.

Yet, many commercial applications still require a low cost solution with an even smaller smallest running diameter feature of the belt, e.g. at application in the drive line of scooters, or under the bonnet of a personal vehicle where space is scarce. Scooters have, located near the rear wheel, a relatively bulky transmission case as part of the drive line. The drive line, in particular the bulkiness thereof limits the design freedom of this two wheeled motorised vehicle.

One manner for attaining a very small running diameter of a rubber belt is to design a relatively wide width belt with a plurality of endless V-shaped grooves provided longitudinally to the interior, i.e. the radial inner side of the belt. In this manner a belt of relatively low height, allowing a relatively small smallest running diameter is attained. In this solution the ratio is fixed and the belt is no longer applicable in a variable transmission.

Another disadvantage of the known V-belt is that the rubber body required for proper clamping between the sheaves of a pulley is entirely disposed at the radial inner side of the tensile means. Location at the radial outer side of the tensile means could cause the rubber body part to deform, i.e. to bulge out in radial direction, under the clamping action. The deformation may be such that the function of the body is lost at least to a large extent. Bulging out is in conventional V-belts a.o. counteracted by a radial outer layer of reinforced material. The clamping body for the belt is consequently situated below the tensile means, i.e. at the radial inner side of the belt. When transmissions with small diameters are sought for, e.g. at limited space applications, this phenomenon reduces the range of transmission ratios that can be attained.

Another solution known in the art of pull belts is provided by EP-A-0 826 901. This solution describes a relatively expensive belt of a relatively complicated structure, directed to and particularly suitable for relatively high power transmission systems. The design of this belt features transverse elements, so called blocks, having a fixed position relative to a tensile means, denoted load carrier. The load carrier consists of two endless parts, each of which is placed into laterally extending slots of the transverse elements. The load carriers each have a rubber like elastically deformable

material body of noticeable height, in which a centred layer of tensile elements in the form of strings is incorporated. The tensile means and the manner of incorporation correspond to what is known from conventional V-belts, and have the associated drawback of limited transfer of force per unity of width. The transverse elements of this type of belt are produced with a metal core coated with a synthetic material so as to achieve both a desired amount of axial stiffness and a required amount of friction with the sheaves of a pulley. This design renders a relatively complicated manufacture. Also, the body of the load carriers or tensile means show a relatively complicated profiled shape, different at the radial inner and the radial outer surface, and matching the profiling of the lateral slots of the transverse elements. After the driving force has been transmitted from the sheaves to the transverse elements, the latter carry this force over to the tensile bodies by said different upper and lower profiling. Subsequently the force is conducted from the body of the load carrier to the layer of cords in the conventional manner. The profiling of the elements and of load carrier per se, each with two shapes, may disadvantageously form an additional drawback at manufacture of the belt.

Yet another proposal for improvement of the conventional V-belts is provided by US 4,915,677. The publication discloses a pull belt with one or a plurality of a so-called tension resistant member, embodied by a layer of cables. This known pull belt is provided with transverse elements preferably of a metal material which are opened to the radial outer side by a recess. The bottom side of the recess is profiled for receiving a plurality of cables disposed in a layer at a level in the upper, i.e. radial outer half of the elements. For the sake of improvement of the force distribution in the element, a filler element is present, filling the recess and aiding in the bonding between the cables and the elements. The bonding is enhanced by an elastomeric mass joining the transverse elements and the tension resistant member. Thus, also the design proposed by this document suffers from the drawback of the conventional V-belt, in that the transmittable force is limited by the force transmittable from the elastomeric body to the cables incorporated therein. Moreover fabrication, i.e. manufacture is also complicated by the requirement of precisely receiving the cables in the relevant recesses between the element and the filler. A disadvantage exists in that the pulley contacting limbs tend to deflect inwardly under high pressure, so that insufficient clamping force is taken up by the element as a whole. It was suggested to fill up the recess for receiving the tensile means, i.e. the space between the limbs by a filler plate, preferably to be welded between and against said limbs. This solution complicates the

design of the belt and raises production costs. The belt according to this solution was dimensioned to accommodate relatively large power transmissions.

The present invention thus seeks to improve the pull belt type for variable transmissions in such a manner that a relatively small smallest running diameter can be attained at application in a transmission, in particular a continuous variable transmission, without undue sacrifice to durability, i.e. life span of the belt, nor to force transmittable by the belt, and without undue complication of the design and manufacture of the belt. In particular the invention aims to provide a design technically and economically applicable and without undue manufacturing efforts, more in particular in the area of relatively small power transmissions like at the conventional rubber V-belt designs.

According to the invention, such is attained by the characterising portion of claim 1. The ultimately thin tensile element as featured in the design according to the invention effects a very low bending stress in the tensile element, thus enables a relatively long life time of the belt, or very small smallest running diameter of the belt at equal life time. This feature of the invention is made possible by a measure to extend the tensile element over a broadest possible width, i.e. possibly as broad as the belt or any element incorporated therein, however without contacting the sheaves of the pulley. In practice good results may be achieved with the width being from 0.5 up to 1 times the width of the belt or, if transverse elements are incorporated in the belt, from 0,5 to 0,9 times the width of the element at the effective running diameter of the belt. The tensile element is according to the invention preferably located central to the radial height of the belt. By this measure according to the invention, the tensile stress within the tensile means is reduced to a minimum, specifically since it is combined with the feature of being a thin bladed means, i.e. having radial thickness of minimal amount.

By the above said features a belt according to the invention may in a first embodiment be used favourably both as a replacement of V-belts having a plurality of longitudinal grooves, since it requires only a small amount, in a flat layer of elastically deformable material, preferably at each side of the tensile means for creating a comparable amount of friction surface, while it may be bend easily over even smaller diameters and with equal contacting features at both radial sides of the belt.

The belt according to the invention may in a further elaboration also favourably be applied as a replacement of the tensile means as used in an arrangement like EP-A-0826901 by adopting the appropriate profiling for the elements thereof. With a belt

according to the present invention, the said V-belt arrangement may adopt even smaller running diameters, smaller pitch distances and higher power throughput.

In a third embodiment of the invention the belt is produced suitable for a continuous variable transmission by the provision of transverse means having a centre opening through which the tensile means is passed, and with an elastically deformable material located longitudinally in between the transverse means, and having an adhesive connection with a radial surface of the tensile means.

In the above embodiments of the invention, a double layer of ultra thin material, is favourably applied, of which according to the invention radial facing sides are mutually connected, either mechanically or by an ultra thin layer of gluing material such as metal glue, an ending piece of strap is made endless. This is according to the invention most favourably performed when at least virtually the entire longitudinal length of so created endless means is provided with a double layer. Preferably however, a minimal overlapping part of three layers is created, e.g. up to 5% of the longitudinal length. In case the belt according to the invention is provided with transverse elements according to the invention, no in between glue is required, since use is favourably made of an intermediate elastically material adhered to both radial sides of a combined layer of tensile means, preventing the tensile means from being pulled to a loose assembly, forming a particular embodiment of mechanical connection between end parts of a single strap element.

The invention may also be characterised as a tensile belt where elasticity and stiffness requirements of the different subcomponents are split up in such a way that they are optimal for the requirement of that component. This leads to a tensile belt that is suitable for very small running radii and which has minimal internal losses leading to a high efficiency belt and low operating temperatures, which is specially important for belts that are partially or completely composed of polymers and/or elastomers.

In the current belt, transverse elements that are stiff enough to prevent deformation of the belt between the pulleys, reducing internal friction losses and forming a beam to resist the required clamping force of the pulley sheaves. These elements may favourably relatively easily be provided with a relatively high resistance to wear. The belt further includes spacing means of an elastic material with negligibly modules of elasticity to eliminate bending stresses in the belt and with a good bonding performance with the radial surface of e.g. a metal strap like tensile means. Thus a good transport of driving force from the tensile element to the transverse elements or vice versa is made possible. The spacing means is in this arrangement compression

loaded by the force transfer between tensile element and transverse element and vice versa, preventing peel of the bonding layer between spacing means and tensile element.

When a double layer of tensile sheet element is used, according to a specific embodiment of the invention, a heavy duty metal grease is used between them, while the sides are being sealed with a same elastomere as for the spacing means, leading to wear reduction between the layers.

The invention will now be elucidated further according to a drawing in which:

FIGURE 1A to 1C relate to conventional rubber V-belts;

FIGURE 2 is a first embodiment of the V-belt according to the invention, with transverse elements mechanically coupled to a tensile means;

FIGURE 3 is a first alternative embodiment of a V-belt according to the invention;

FIGURE 4 is a perspective view of second and preferred alternative embodiment of the V-belt according to the invention;

FIGURE 5 is an illustration of different techniques according to the invention for realising an endless tensile means within the belt;

FIGURE 6 schematically shows an alternative and preferred embodiment of the tensile means, i.e. consisting of two layers;

Figure 7 illustrates an advantage of the belt according to the invention when applied as a replacement belt for a conventional belt;

Figure 8 illustrates a preferred shape of the transverse elements;

Figure 9 by sectional views of different transverse elements, illustrates possible shapes of a transverse element according to the invention;

FIGURE 10 illustrates a common manner of operating a conventional rubber V-shaped belt in a continuously variable transmission;

FIGURE 11 illustrates the possible reduction in dimension of a transmission or variator when the belt according to the invention is applied instead of a conventional belt.

The following description departs from the overall shapes and elements of a V-belt and of the associated and mentioned manufacturing processes as commonly known per se. The invention is primarily found in the new design of the belt. Secondly the order and manner of assembling the separate components in the belt according to the invention are mentioned.

In figure 1, three conventional rubber belt types are represented, a first one suited for transmissions having a fixed transmission ration. A second one typically

adapted for variable ratio transmissions, and a third one typically adapted for uses with small running diameters, however, only suitable for a fixed ratio transmission.

In figure 1A the conventional rubber V-belt 1 for fixed ratio transmission is shown with an outer coating 2 all around the belt 1. It has a rubber body 5 of soft elastic nature, and a thin outer coating of a relatively hard elastic nature, however providing resistance to wear. Embedded in an embedding layer 3 of material specifically suitable for connecting to a tensile means 4. The tensile means 4 consists of a layer of relatively thin rope, e.g. a Kevlar material, wound equally distributed over the width of the belt. The radial thick body 5 prevents the belt from adopting small running diameters, however promotes a stable running of the belt in the V-groove between the sheaves of a pulley.

The belt according to figure 1B is modified in that no surrounding is outer body is provided, in that the body is of a stiffer rubber type and is at the radial inner side provided with transverse grooves, commonly distributed at even distances of between 0.8 and 1.5 cm. At the radial outer face, a reinforced layer of relatively stiff material 6 is provided, supporting the stiffness of the belt in axial direction, thereby enhancing the efficiency of the belt.

The belt according to figure 1C is provided with V-shaped grooves 8 extending in longitudinal direction, thereby increasing, i.e. regaining contacting area with correspondingly grooved fixed ratio pulleys of a small running diameters. No outer support layer 6 is required since the belt is not loaded with axial thrust originating from sheaves of a pulley.

Figure 2 represents a first principal modification of the V-type pull belt in accordance with an idea underlying the invention. It shows a separation in function of a transverse clamping means and a tensile loadable body, in casu embodied by a flat strip of a tensile loadable material, preferably spring type steel or a synthetic tape of a synthetic uni directional (UD-) material. A transverse element is mechanically coupled to the tensile body, in casu by a pop nail construction known per se, wherein the nail is part of the transverse element. Internally it shows a U-shape, of which the bottom part forms a contacting face for contacting the tensile body. It is of a width matching that of the tensile body. The contacting face is centrally provided with a nail part. The transverse element may be composed of metal but is preferably entirely composed of a synthetic material. The nail part is inserted through an opening in the tensile body, and subsequently popped, either mechanically in case of a metal nail or thermo-mechanically in case of a synthetic material.

The strip forming the tensile body, composed of metal like spring steel or of unidirectional synthetic tape, is of a thickness considerably smaller than that of the cords applied in conventional tensile bodies. Typically the reduction in thickness is of a factor between 5 and 10 times the conventional thickness. According to the invention
5 the metal or synthetic strip applied is of a thickness between 0.04 and 0,25 mm, more preferably up to 0,1 mm, compared to conventional cord thickness of between 0.6 and 1.2 mm. This measure in accordance with the invention effects a considerable reduction of bending stress within the tensile body, implying a longer life time when a belt with such tensile element is run at a corresponding running radius, or an equal life
10 time at a considerably smaller running radius.

The immense reduction in thickness of the tensile element is in accordance with the invention made possible through the fact that the tensile element is produced strip like, i.e. entirely flat. By this feature, compared to conventional layers of cord, the required small amount of space between the cords is entirely occupied in width wise,
15 i.e. lateral and axial direction. Very importantly, by this design of the tensile element, very high contacting pressures between tensile body or ~element may be realised since a danger of the cords cutting through the body of the transverse elements or of an additional layer within the tensile body is strongly if not entirely taken away. In the present design, the transverse element and the tensile body mutually engage for
20 driving action mechanically, both by said inserted nail and by a frictional contact between contacting face and the tensile body. Another characterising feature of a design in accordance with the invention, is that the tensile body is located centred in radial direction relative to the radial height of the contacting faces of the transverse elements, thus further reducing the tensile load and stress on the tensile element in
25 the belt. In the present embodiment where the tensile body is solely formed by a tensile strip, and where the thickness of the strip may virtually be neglected, this implies that the effective point of contact or location of the friction force of a contacting face is located virtually centred relative to the radial height of the contacting faces of the element.

30 Figure 3 represents an alternative construction for the belt according to figure 2, in which the tensile body is provided with lateral ear parts or in reversed sense, with slot like openings. The openings show axial contacting rims by which the tensile body is contacted. The openings have a longitudinal depth fitting the thickness of a transverse element, at least the limb part thereof. The total width of the tensile body is
35 less than the local width of the transverse elements, so as to prevent the tensile body

from contacting the sheaves of the pulley. The axial width of the slotted opening substantially corresponds to the local width of the limbs of the transverse elements. Preferably the openings are created by bending the material originally present in the slot area in downward or upward direction, according to an axial folding line coinciding
5 with an axial contacting rim for contacting a transverse element. The drawing, the transverse element may be provided with retractable limb parts for keeping the tensile element in place. Overlapping ends of the tensile element are fixed in longitudinal direction via said ear parts

The tensile body may also be produced as a tensile strip coated with a an
10 elastically deformable material such as vulcanised rubber or a synthetic rubber material. The presence of the elastic material in this context assists in levelling local pressure peaks, thus enhances lifetime of the belt.

In the embodiments according to figures 4 advantage is taken of the circumstance that in accordance with the invention it is relied on the shear force
15 feature of the elastically deformable material of the intermediate body, rather than on the tensile force coefficient of this material, implying that a relatively high tensile force can be carried over in the tensile means. For the latter reason a V-belt according to the invention may be embodied with a relatively small, i.e. thin layer of elastic material between the ends of the tensile element.

Figure 4 schematically depicts the structure of an embodiment according to the invention in which connection between the tensile element and the transverse element is realised through an elastically deformable material, firmly bonded, i.e. adhesively connected to the strip element, e.g. glued or otherwise bonded, with the material preferably extending over the width of the strip. In the embodiment according to figure
20 4, first the elements are shifted over the tensile element after which the elastic material is applied. According to an alternative embodiment of a manufacturing process, the tensile element is first coated with the elastic material after which the transverse elements are shaped with an injection moulding machine. In both embodiments for a manufacturing process the tensile body consists of a mirrored profiling at each of both
25 radial inner and outer surface face of the tensile means. The elastic material is at least present longitudinally in between two adjacent transverse elements and is firmly connected to the strip element, i.e. it has an adhesive bonding, either or not enhanced by mechanical or chemical treatment of the radial surface area of the tensile means. It has a very high resistance against shear and peeling, alternatively denoted a high
30 coefficient of adhesion. Preferably vulcanised rubber is used for this purpose,
35

however, also a combination of dedicated surface treatment and a subsequent application of synthetic rubber showed useful results.

The transverse element in these embodiments extends two sided over the tensile body, thus shows a centralised slotted opening fitting a cross section of the tensile body. In accordance with the invention, the elements are moulded in location around the tensile means. Equally however, the transverse elements may be cut out of a piece of suitable material, or may be individually (injection) moulded and subsequently be tacked or stringed to the tensile strip, brought into mutually correct position by means of a mall. In case of moulded elements, a distance boss is provided to the elements. Subsequently the elastic material is provided by injection or transverse moulding, intermediate to the transverse elements. Application of the intermediate elastic material in the embodiment according to figure 4 can e.g. be done by one or more injection nozzles directed to the surface of the tensile strip. At each embodiment, the elastic material is provided over a thickness of more than 1 mm above the strip surface and preferably at a maximum of half or less than a quarter of the total radial height of the contact face of a transverse element. However, the gap between transverse elements may without undue influence to the basic function of the belt also be filled entirely.

Preferably the central opening in the transverse element shows a rounding or a chamfer of the edges as seen in radial and – belt wise - longitudinal cross section. In this manner both the tacking of the elements over the strip is enhanced by the presence of a funnel like entry of the opening. Also, the contact between the element and the elastic material is optimised. Further it is realised that any damaging contact between element and tensile strip, likely to be caused by a high surface pressure due to sharp edges at the element is minimised. The latter shape of the element slot according to the invention, at driving activation of a transverse element by the sheaves of a pulley, urges the element on to the intermediate material. By the chamfer or otherwise manner of rounding, a funnel-like opening is created at the central opening of the element. The elastic material between two transverse elements, by the funnel shape, tends to become gradually compressed towards the surface of the tensile strip under the influence of any longitudinal driving force of a transverse element, thus causing the internal friction capacity of the elastic material and the friction with the strip surface to be increased, optimising the transfer of driving power from the transverse element to the tensile strip. Figure 8 and 9 show examples of such above described funnelled openings, in casu with a rounded, respectively chamfered opening. Due to

subsequent injection of the intermediate material, the latter adopts the shape created in the opening of the element.

In the embodiment according to figure 4, the belt according to the invention may be produced by coating the strip element first, with a rubber or synthetic rubber like material, preferably in a profiling matching the above described chamfer or rounding, preferably symmetrically at both radial sides of the tensile body, and subsequently moulding the transverse elements in place, using a suitable mall for maintaining the tensile body in a desired position and shaping the transverse elements.

In accordance with the invention the transverse elements are produced of a very stiff, i.e. non-compressible synthetic material, preferably fibre reinforced, having a high temperature resistance, i.e. preferably over 100 or even up to 150 degrees Celsius, and with a reasonable coefficient of friction in combination with metal sheaves. One such material is of the acetal group (POM). Any alternative matching such criteria, such as high tech thermosets like phenol based materials or high tech engineering plastics with or without fibre filling may equally be applied however. Although a metal transverse element could be used, the invention applies a synthetic material so as to more easily provide the elements with the desired shape details, and so as to enhance manufacturing of the elements and equally to enhance assembly of the belt according to the invention.

Figure 5 illustrates several manners of realising an endless tensile means produced in a single layer effectively. The upper manner simply shows two end parts of a tensile means overlapping radially. A mechanical stopping means may be provided according to the invention, either by bending an end part of the tensile means transverse to the longitudinal direction, or by locating a rim on a radial face, e.g. a soldered rim. The lower most part of the drawing illustrates a manner of welding the two end faces of the tensile means. The tensile means is for this purpose cut obliquely.

Figure 6 in accordance with the invention shows a preferred manner of incorporating a tensile element in the new V-belt. In this shown embodiment the tensile means is produced in two layers. In the embodiment shown the tensile means consists of two parts. Preferably, though not depicted, the tensile means is produced of one piece, with the ends overlapping to a small extend. In both embodiments the ends are mutually interconnected via the transverse elements. Additional mechanical connections may be used, e.g. via the intermediate elastically deformable means. In this manner the tensile element is virtually made endless. The thickness of the

element is in this case taken half the thickness required for transferring a force in the embodiment with one layer effectively.

Figure 7 shows a further advantage of the present invention which is most favourably used when the current belt is applied as a replacement belt for a conventional rubber belt, i.e. in a variator of otherwise conventional dimension. Since the tensile means is located radially centred, the driving force of the transmission is effectively located at radial lower point of up to 5 mm. This phenomenon is of a relative high significance at the smallest diameter, compared to the situation at the other driving wheel where the largest running diameter occurs at such instance. Thus in the initial stage of transmission, an improved so called launch performance, e.g. at scooters is achieved.

Figure 8 in detail shows a preferred embodiment of a transverse element, with distance bosses for mutually easily positioning the elements when strung on a tensile element. The bosses are located at the radial level of the tensile means. By the cross section on the right hand side of the figure, the rounded contact face of the elements for contacting the tensile means is shown, creating the earlier described, and favourable funnel shape. However, as illustrated by the comparable cross sections in figure 9, different shapes be chosen, including a triangular wedge shape and a simple slotted opening.

Advantages of the belt according to the invention include the reduced smallest possible running diameter, and the small, material saving transmission case consequently required, an increased efficiency of the belt due to reduction of internal losses otherwise caused by compression, both in longitudinal and in axial direction, and an increased life time of the belt due to the use of reinforced, non-compressible synthetic material in the transverse elements, and to the reduced tensile stress in the tensile element, due to it's strongly reduced thickness. Moreover, the belt according to the invention may realise a significantly increased transfer of power due to the lower position of the tensile element as compared to conventional rubber V-belts.

Figure 10 and 11 together provide an indication of the effects attainable with a belt according to the present invention. In Figure 10, schematically part of transmission line of a scooter is shown with the contour of a pulley sheave to the front side at the left hand side of the figure and one to the rear side at the right hand side in the figure. At the front side the smallest possible running diameter is utilised since the take off or launching of a vehicle is only short lived. At the rear wheel however, the smallest running diameter, occurring in overdrive (OD) situation occurs most of the operation

time of the vehicle. So as to enhance life time of the belt, the smallest running diameter is commonly limited to a diameter about twice that of the smallest diameter at the front pulley. With a belt designed in accordance with the invention, such limitation may be omitted. Moreover the smallest possible running diameter is even further
5 reduced, so that for achieving a comparable transmission ratio, the diameter of the pulleys may be reduced.

Figure 11 shows that the overall length of a transmission drive line may be significantly reduced. This may amount from about 75% of the smallest possible distance between the axes of two conventional pulleys up to almost 50% of the
10 currently applied space between the pulleys of nowadays scooters. Thus the invention also relates to a scooter or alike vehicle, having a variator, with a belt according to the invention, and integrated with the engine, i.e. incorporated within the dimensions thereof, and having a fixed ratio transmission, e.g. by a belt between the variator and the rear wheel. When a belt according to the invention is merely applied as a
15 replacement belt, i.e. with a conventional dimensioning of the variator, still a significant advantage exists in a structurally higher potential of transferring power due to the low position of the tensile element. It may a.o. be used to enhance the driving characteristic of such vehicle in the LOW driving mode. For instance, the coupling may be tuned to close somewhat earlier, so that a driving force may already be transferred
20 at lower engine speed, due to the enhanced torque transmission capacity in combination with a belt according to the invention.

The invention apart from the preceding description and all details of the drawing in particular relates to the following set of claims.

CLAIMS

1. Drive belt for rotational transfer of a force between two or more drive wheels, provided with a tensile means for transferring the force to be transferred between said
5 drive wheels, characterised in that, the tensile means is incorporated radially centred in the belt, provided with a strip or sheet like tensile means of minimal thickness, and of a width at least substantially corresponding to the width of a contact body disposed on to at least one radial side of said tensile means, effecting a contact between the belt and a drive wheel.
- 10 2. Drive belt according to claim 1, for rotational transfer of a force between two or more drive wheels, provided with a tensile means for transferring the force to be transferred between said drive wheels, and a contact body for realising contact between the belt and the drive wheels, the contact body being composed of a plurality
15 of transverse elements, and between which transverse elements, as taken in the longitudinal direction of the belt, in adhesive contact with the tensile means, is provided an intermediate body of a relatively soft elastically deformable material, characterised in that the tensile means comprises a strap like means of minimal
20 thickness, the width of which strap like means substantially corresponding to the width of the contacting body at the level of the tensile means in the belt, and the strap like means being incorporated in the belt with radial overlapping end parts.
3. Belt according to claim 1, 2 or 3, characterised in that the tensile means is composed of a metal material, preferably spring type metal or of a UD-material.
4. Belt according to any of the preceding claims, characterised in that the tensile
25 means is comprises an elastically deformable, rubber like material, coated on to the tensile element, such that a small layer of material is located in a contact between the tensile element and a transverse element, in particular forming part of the intermediate body.
5. Belt according to any of the preceding claims, characterised in that the tensile
30 element is of a thickness less than 0.5 mm, preferably less than 0,25 mm, in particular 0,1 mm or less.
6. Belt according to any of the preceding claims, characterised in that the width of the tensile means at least substantially corresponds to the width of a transverse

element, the width of the transverse element slightly extending beyond the tensile means.

7. Belt according to any of the preceding claims, characterised in that the element thickness is less than 0,20 times the smallest running radius, in particular less than 1,5 mm.

8. Belt according to the preceding claim characterised in that the intermediate body has an elasticity modulus more than 6 times lower than that of the transverse elements.

9. Belt according to any of the preceding claims, characterised in that the mutual distance of the transverse elements corresponds to the thickness of the elements;

10. Belt according to any of the preceding claims, characterised in that the maximum height of the intermediate body corresponds to the mutual distance between the elements.

11. Belt according to any of the preceding claims, characterised in that the intermediate body is provided over at least a substantial part of the width of the tensile means.

12. Belt according to any of the preceding claims, characterised in that the maximum height of the intermediate body is less than half of the transverse element height taken from the relevant radial side of the tensile means to the relevant radial end of the transverse means.

13. Belt according to any of the preceding claims, characterised in that the intermediate body is adhesively attached to the relevant radial face of the tensile means.

14. Belt according to any of the preceding claims, characterised in that the maximum element height is less than half of the nominal element width.

15. Belt according to any of the preceding claims, characterised in that the transverse element is composed of acetals (POM) or high tech thermoplastic or thermoset engineering plastics.

16. Belt according to any of the preceding claims, characterised in that the tensile means is composed of a single part which is curled to an endless element.

17. Endless pull belt, in particular according to any of the preceding claims, more in particular V-belt for application in a transmission with a V-wedged pulley, more in

- particular a variable width pulley, comprising a tensile means and transverse elements comprising a V-shape with lateral pulley contacting faces, an elastically deformable spacing means being located longitudinally between said elements, characterised in that tensile means comprises a flat, strip like tensile element of a minimal thickness
- 5 TT, i.e. $0,05 \text{ mm} \geq TT \leq 0,25 \text{ mm}$, extending over a width WT, substantially matching the nominal width WB of an element, i.e. $0.5 \cdot WB \geq WT \leq 0.9 \cdot WB$, the element being located centred over the radial height of an element in the belt, the tensile element further being composed like a single body, preferably a strip composed of metal material or of a synthetic UD-material.

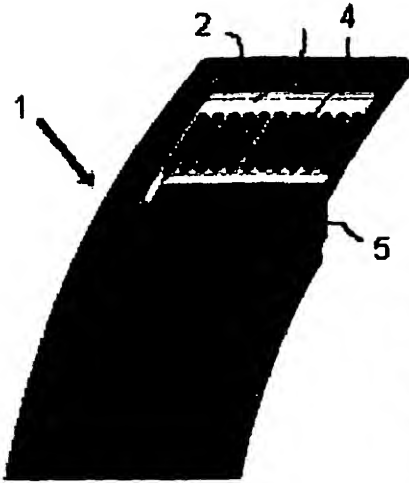


FIG. 1A

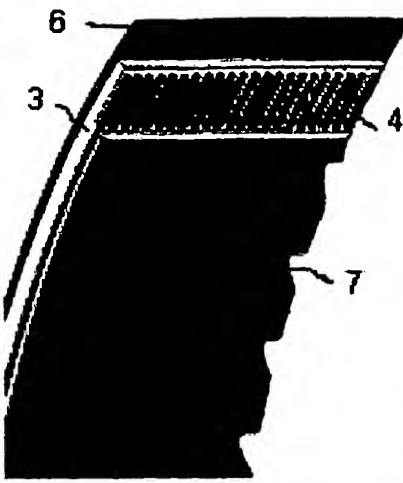


FIG. 1B

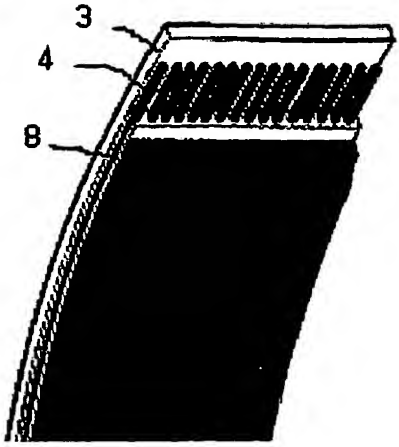


FIG. 1C

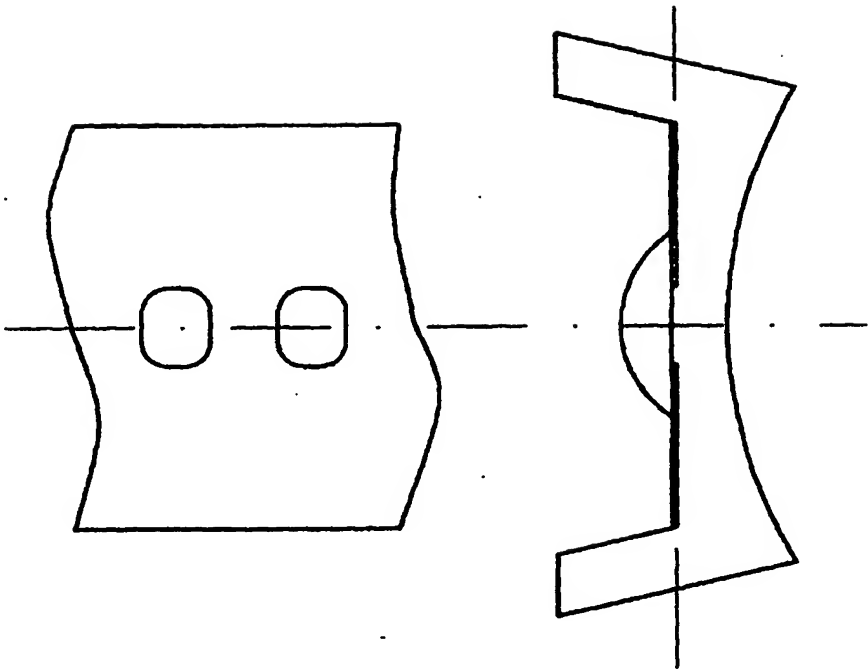


FIG. 2

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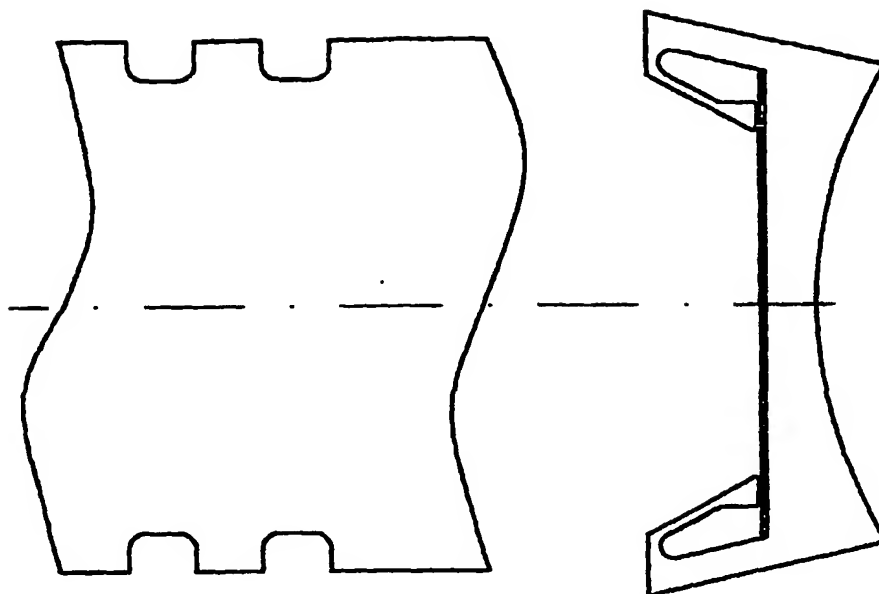


FIG. 3

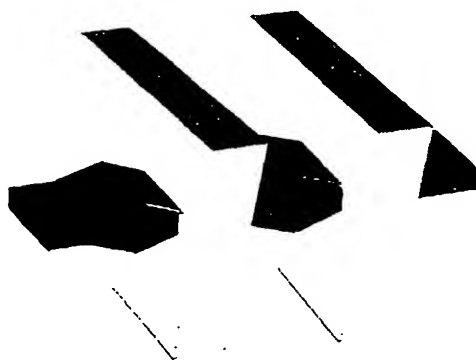


FIG. 4

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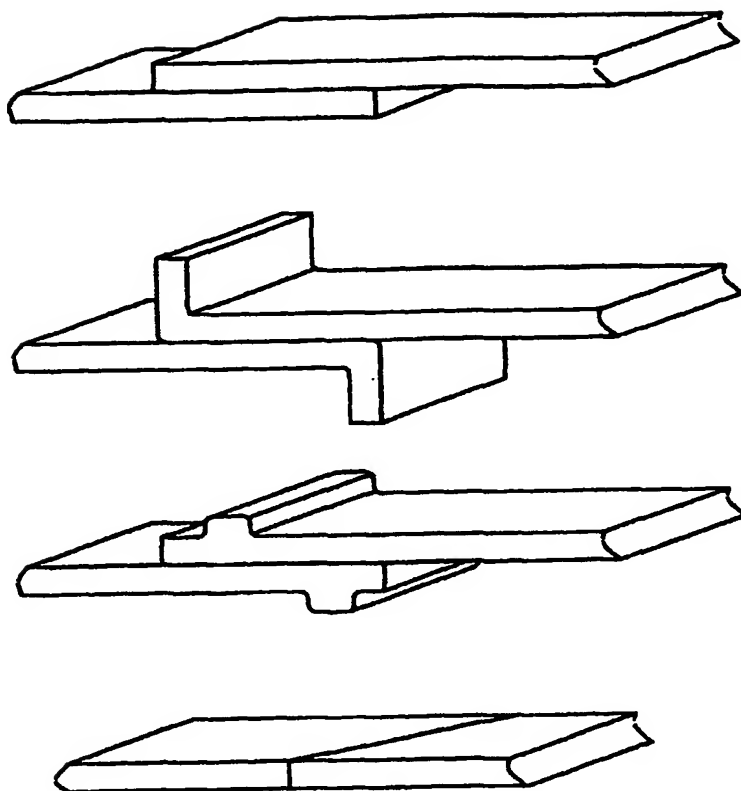


FIG. 5

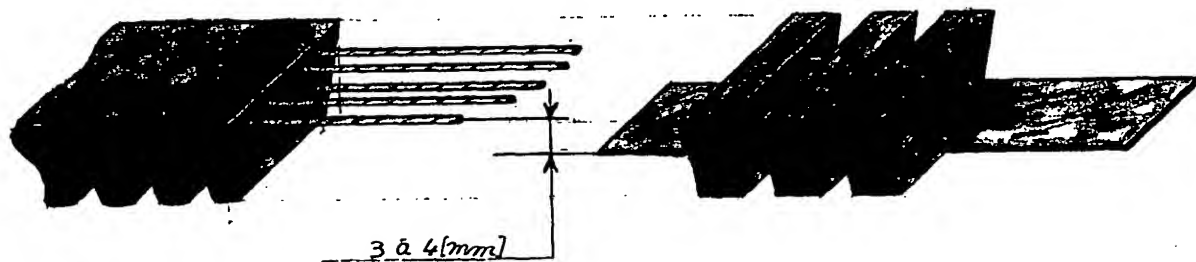


FIG. 7

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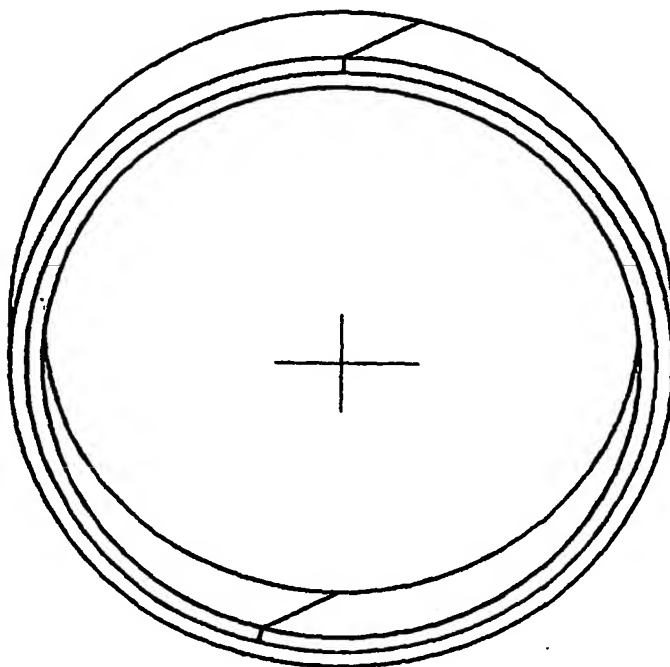


FIG. 6

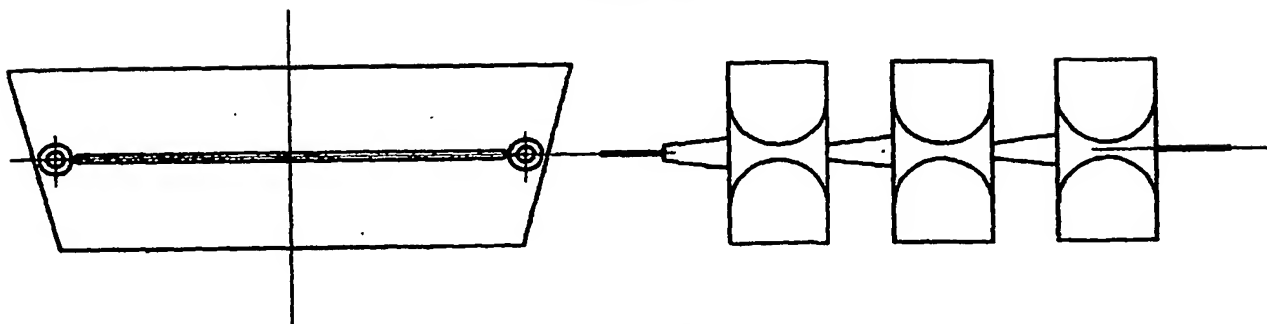


FIG. 8

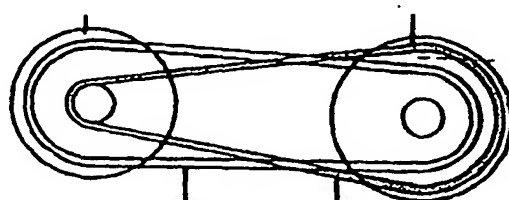


FIG. 10

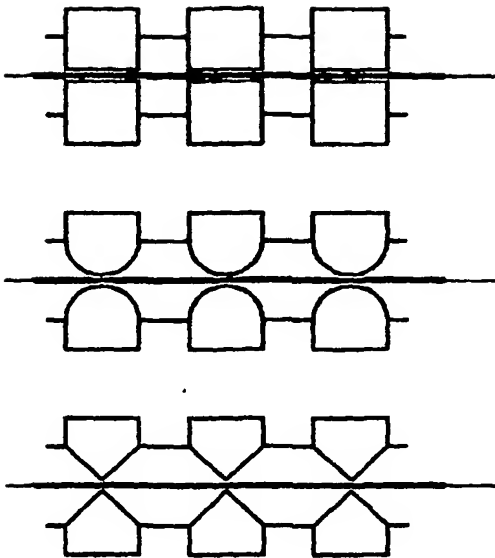


FIG 9

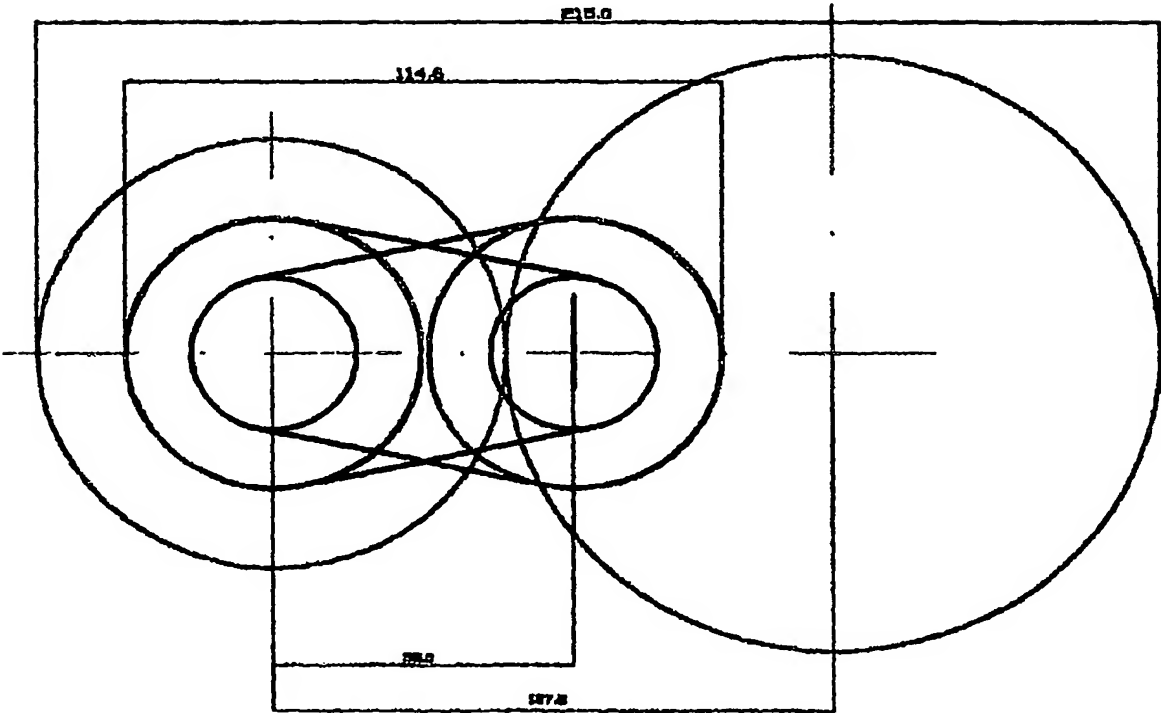


FIG 11

INTERNATIONAL SEARCH REPORT

International Application No.

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A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 F16G5/16

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

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Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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X	FR 1 097 864 A (DAMIRON PAUL) 12 July 1955 (1955-07-12) page 2, left-hand column, line 41 - line 43; figure 2 ---	1,3,6,9, 14-16
X A	FR 792 144 A (PLISSON ALFRED ERNEST; GODEL EDOUARD) 23 December 1935 (1935-12-23) the whole document --- -/--	1,3,6,16 17

☒ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

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Date of the actual completion of the international search

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Date of mailing of the international search report

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INTERNATIONAL SEARCH REPORT

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C-(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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Information on patent family members

International Application No

PCT/IB 03/02458

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02077769.4 25 June 2002 (25.06.2002) EP
- (71) Applicant (for all designated States except US): **LS VARIO SYSTEMS B.V.** [NL/NL]; Smidspad 22, NL-5046 JC Tilburg (NL).
- (72) Inventors; and
- (75) Inventors/Applicants (for US only): **SMEETS, Paulus, Maria** [NL/NL]; Smidspad 22, NL-5046 JC Tilburg (NL). **LUNSHOF, Jan, Halbe** [NL/NL]; Bolmanstraat 7, NL-2496 RE Den Haag (NL).
- (81) Designated States (national): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD, SE, SG, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZM, ZW.
- (84) Designated States (regional): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO, SE, SI, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Declarations under Rule 4.17:

- as to the identity of the inventor (Rule 4.17(i)) for the following designations AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD, SE, SG, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, UZ, VN, YU, ZA, ZM, ZW, ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO, SE, SI, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG)
- as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii)) for the following designations AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD, SE, SG, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, UZ, VN, YU, ZA, ZM, ZW, ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO, SE, SI, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG)
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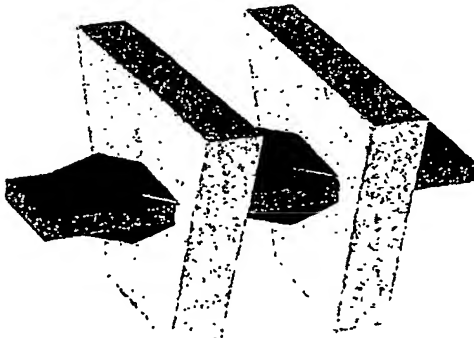
Published:

- with international search report
- with amended claims

Date of publication of the amended claims: 11 March 2004

[Continued on next page]

(54) Title: PULLING V-BELT



(57) **Abstract:** The invention relates to a drive belt for rotational transfer of a force between two or more drive wheels, provided with a tensile means for transferring the force to be transferred between said drive wheels, and a contact body for realising contact between the belt and the drive wheels, the contact body being composed of a plurality of transverse elements, and between which transverse elements, as taken in the longitudinal direction of the belt, in adhesive contact with the tensile means, is provided an intermediate body of a relatively soft elastically deformable material. The tensile means comprises a strap like means of minimal thickness, the width of which strap like means substantially corresponding to the width of the contacting body at the level of the tensile means in the belt, and the strap like means being incorporated in the belt with radial overlapping end parts.

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For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

AMENDED CLAIMS

[received by the International Bureau on 23 January 2004 (23.01.04);
original claims 1-17 replaced by new claims 1-21 (3 pages)]

1. Drive belt (10) (10) for rotational transfer of a force between two or more drive wheels, provided with a tensile means (11) for transferring the force to be transferred
5 between said drive wheels, in which the tensile means (11) is incorporated radially centred in the belt, which belt is provided with transverse elements (13) disposed on to at least one radial side of said tensile means (11), effecting a contact between the belt (10) and a drive wheel, and in which elastically deformable material (12) is included
10 that the tensile means (11) is composed of a flat strip or sheet like tensile means of minimal thickness, and of a width at least substantially corresponding to the width of a transverse means (13).
2. Belt (10) according to claim 1 characterised in that the tensile means (11) is included in the belt (10) with overlapping end parts (20).
- 15 3. Belt (10) according to claim 1 or 2, characterised in that the width of which strap like means (11) substantially corresponding to the width of the transverse means (13) at the level of the tensile means in the belt (10), and in that the strap like means (11) is incorporated in the belt (10) with radial overlapping end parts (20).
4. Belt (10) according to claim 1, 2 or 3, characterised in that the tensile element
20 (11) is composed of a metal material, preferably spring type metal or of a UD-material.
5. Belt (10) according to any of the preceding claims, characterised in that the tensile means (11) comprises an elastically deformable, rubber like material (12), coated on to the tensile element (11), such that a small layer of material (12) is located in a contact between the tensile element (11) and a transverse element (13).
- 25 6. Belt (10) according to any of the preceding claims, characterised in that the tensile element (11) is of a thickness less than 0.5 mm, preferably less than 0,25 mm, in particular 0,1 mm or less.
7. Belt (10) according to any of the preceding claims, characterised in that the width of the tensile means (11, 12) at least substantially corresponds to the width of a
30 transverse element (13), the width of the transverse element (13) slightly extending beyond the tensile means (11, 12).

8. Belt (10) according to any of the preceding claims, characterised in that the element (13) thickness is less than 0,20 times the smallest running radius, in particular less than 1,5 mm.
9. Belt (10) according to the preceding claim characterised in that the elastical
5 deformable material (12) has an elasticity modulus more than 6 times lower than that of the transverse elements (13).
10. Belt (10) according to any of the preceding claims, characterised in that the mutual distance of the transverse elements (13) corresponds to the thickness of the elements (13).
- 10 11. Belt (10) according to any of the preceding claims, characterised in that the maximum height of the intermediate body (12) corresponds to the mutual distance between the elements (13).
12. Belt (10) according to any of the preceding claims, characterised in that the intermediate body (12) is provided over at least a substantial part of the width of the
15 tensile means (11).
13. Belt (10) according to any of the preceding claims, characterised in that the maximum height of the intermediate body (12) is less than half of the transverse element height taken from the relevant radial side of the tensile means (11, 12) to the relevant radial end of the transverse means.
- 20 14. Belt (10) according to any of the preceding claims, characterised in that the intermediate body (12) is adhesively attached to the relevant radial face of the tensile means (11).
15. Belt (10) according to any of the preceding claims, characterised in that the maximum element (13) height is less than half of the nominal element width.
- 25 16. Belt (10) according to any of the preceding claims, characterised in that the transverse element (13) is composed of acetals (POM) or high tech thermoplastic or thermoset engineering plastics.
17. Belt (10) according to any of the preceding claims, characterised in that the tensile means (11) is composed of a single part which is curled to an endless element.
- 30 18. Endless pull belt, in particular according to any of the preceding claims, more in particular V-belt for application in a transmission with a V-wedged pulley, more in particular a variable width pulley, comprising a tensile means (11, 12) and transverse

- elements (13) comprising a V-shape with lateral pulley contacting faces, an elastically deformable spacing means (12) being located longitudinally between said elements (13), characterised in that tensile means (11, 12) comprises a flat, strip like tensile element (11) of a minimal thickness TT, i.e. $0,05 \text{ mm} \geq TT \leq 0,25 \text{ mm}$, extending
5 over a width WT, substantially matching the nominal width WB of an element (13), i.e. $0,5 * WB \geq WT \leq 0,9 * WB$, the tensile element (11) being located centred over the radial height of a transverse element (13) in the belt (10), the tensile element (11) further being composed like a single body, preferably a strip composed of metal material or of a synthetic UD-material.
- 10 19. Belt according to any of the preceding claims, characterised in that an opening (15) in the transverse element for receiving the tensile element (11) comprises a funnel like shaped entry.
20. Belt according to any of the preceding claims, characterised in that an
15 opening (15) in the transverse element for receiving the tensile element (11) is located centralised in the element (13).
21. Belt according to any of the preceding claims, characterised in that the transverse element (13) comprises distance bosses (16).

INTERNATIONAL PRELIMINARY EXAMINATION REPORT
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Rec'd PCT/PTO 27 DEC 2004

REC'D 10 AUG 2004

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Applicant's or agent's file reference VS01	FOR FURTHER ACTION See Notification of Transmittal of International Preliminary Examination Report (Form PCT/PEA/416)	
International application No. PCT/IB 03/02458	International filing date (day/month/year) 25.06.2003	Priority date (day/month/year) 25.06.2002
International Patent Classification (IPC) or both national classification and IPC F16G5/16		
Applicant LS VARIO SYSTEMS B.V.		



- This international preliminary examination report has been prepared by this International Preliminary Examining Authority and is transmitted to the applicant according to Article 36.
- This REPORT consists of a total of 5 sheets, including this cover sheet.

☒ This report is also accompanied by ANNEXES, i.e. sheets of the description, claims and/or drawings which have been amended and are the basis for this report and/or sheets containing rectifications made before this Authority (see Rule 70.16 and Section 607 of the Administrative Instructions under the PCT).

 These annexes consist of a total of 20 sheets.

- This report contains indications relating to the following items:

I	<input checked="" type="checkbox"/>	Basis of the opinion
II	<input type="checkbox"/>	Priority
III	<input type="checkbox"/>	Non-establishment of opinion with regard to novelty, inventive step and industrial applicability
IV	<input type="checkbox"/>	Lack of unity of invention
V	<input checked="" type="checkbox"/>	Reasoned statement under Rule 66.2(a)(ii) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement
VI	<input type="checkbox"/>	Certain documents cited
VII	<input type="checkbox"/>	Certain defects in the international application
VIII	<input type="checkbox"/>	Certain observations on the international application

Date of submission of the demand 23.01.2004	Date of completion of this report 09.08.2004
Name and mailing address of the international preliminary examining authority:  European Patent Office D-80298 Munich Tel. +49 89 2399 - 0 Tx: 523656 epmu d Fax: +49 89 2399 - 4465	Authorized Officer Schäfer, A Telephone No. +49 89 2399-8423 

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**

International application No. **PCT/IB 03/02458**

I. Basis of the report

1. With regard to the **elements** of the international application (*Replacement sheets which have been furnished to the receiving Office in response to an invitation under Article 14 are referred to in this report as "originally filed" and are not annexed to this report since they do not contain amendments (Rules 70.16 and 70.17)*):

Description, Pages

1-13 received on 23.07.2004 with letter of 20.07.2004

Claims, Numbers

1-19 received on 23.07.2004 with letter of 20.07.2004

Drawings, Sheets

1/3-3/3 received on 23.07.2004 with letter of 20.07.2004

2. With regard to the **language**, all the elements marked above were available or furnished to this Authority in the language in which the international application was filed, unless otherwise indicated under this item.

These elements were available or furnished to this Authority in the following language: , which is:

- ☐ the language of a translation furnished for the purposes of the international search (under Rule 23.1(b)).
- ☐ the language of publication of the international application (under Rule 48.3(b)).
- ☐ the language of a translation furnished for the purposes of international preliminary examination (under Rule 55.2 and/or 55.3).

3. With regard to any **nucleotide and/or amino acid sequence** disclosed in the international application, the international preliminary examination was carried out on the basis of the sequence listing:

- ☐ contained in the international application in written form.
- ☐ filed together with the international application in computer readable form.
- ☐ furnished subsequently to this Authority in written form.
- ☐ furnished subsequently to this Authority in computer readable form.
- ☐ The statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the international application as filed has been furnished.
- ☐ The statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished.

4. The amendments have resulted in the cancellation of:

- ☐ the description, pages:
- ☐ the claims, Nos.:
- ☐ the drawings, sheets:

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**

International application No. **PCT/IB 03/02458**

5. ☐ This report has been established as if (some of) the amendments had not been made, since they have been considered to go beyond the disclosure as filed (Rule 70.2(c)).

(Any replacement sheet containing such amendments must be referred to under item 1 and annexed to this report.)

6. Additional observations, if necessary:

V. Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

1. Statement

Novelty (N)	Yes: Claims	1-19
	No: Claims	
Inventive step (IS)	Yes: Claims	1-19
	No: Claims	
Industrial applicability (IA)	Yes: Claims	1-19
	No: Claims	

2. Citations and explanations

see separate sheet

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT - SEPARATE SHEET**

International application No. PCT/IB 03/02458

1 Claim 1 is to be clarified according to Articles 19 (2) and 34 (2),b), last sentence PCT so that it is clear that "an intermediate body (12) of elastically deformable material is included **t o b e c o m p r e s s e d** between the tensile means (11)" , cf. page 10, line 32, to page 11, line 3, and not as outlined in present claim 1, in general terms, and not originally disclosed that "an intermediate body (12) of elastically deformable material is included **f u n c t i o n a l l y** between the tensile means (11)" implying any kind of interaction between the intermediate body and the transverse elements.

2 Under the assumption that claim 1 describes a subject-matter according to the comments above in order to comply with Article 19 (2) PCT and Article 34 (2) ,b) PCT, respectively, the subject-matter of claim 1 is not only new but it also involves an inventive step.

3 Actually, the subject-matter of claim 1 is distinguished from the closest prior art known from FR-A-2 515 296 in that

(ch) the tensile means (11) is composed solely of a flat strip or sheet like tensile means of minimal thickness, and in that the intermediate body (12) has an adhesive connection with a radial face of the tensile means (11), in which the slotted openings of the transverse elements (13) fit with [sic !] a cross section of the tensile means (11)

resulting in optionally different materials and different cross sectional design of the tensile means and the intermediate body, this in favour of optimized driving power transfer by means of compression of the intermediate body (irrespective of the material of the tensile means), and in favour of optimized driving power transfer by means of tension of the tensile member (irrespective of the material of the intermediate body).

4 Since the combination of the features (ch) resulting in the said effect are not known from any of the cited prior art documents, it appears that the subject-matter of claim 1 is not only new but it also involves an inventive step, Article 33 (2),(3) PCT.

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT - SEPARATE SHEET**

International application No. PCT/IB 03/02458

- 5 However, the two part form of claim 1 is not correct when starting from the closest prior art known from FR'296 according to which the features (ch) above correspond to the characterising portion and the remaining features of claim 1 correspond to the preamble of claim 1 in order to comply with the requirements of Rule 6.3 b) i),i) PCT.
- 6 The claims 2-19 as they describe embodiments of the subject-matter of claim 1. meet like wise the requirements of Article 33 (2) and (3) PCT.
- 7 The description is not adapted to newly filed claim 1 and, furthermore, the closest prior art document FR'296 is not acknowledged in the description at least as showing only all of the features of the preamble of claim 1, cf. Rule 5.1 a) ii),iii) and 6.3 b) i),ii) PCT.
- 8 On page 6,
line 13: "FIGURE 2" should be cited not "Figure 4",
line 15: "FIGURE 3" it is to be cited not "FIGURE 5",
line 17: "FIGURE 4 " should be cited not "Figure 6",
line 19: "FIGURE 5" should be cited not "Figure 7",
line 21: "FIGURE 6" should be cited not "Figure 5",
line 24: "FIGURE 7" should be cited not "Figure 6" and
line 26: "FIGURE 8" should be cited not "Figure 7"
in view of newly filed drawing sheets 1/3-3/3.
- 9 The requirements of Rule 6.2 b) PCT are not met as the reference signs mentioned in the description are shown in the drawings.
- 10 Figures 1A-1C, 2, 5 and 8 are not clear as it is required by Rule 11.2 (a) and 11.13 (a) PCT as elements shown in these drawings are not clearly represented.

CLAIMS

1. Drive belt for rotational transfer of a force between two or more drive wheels, provided with a tensile means for transferring the force to be transferred between said
5 drive wheels, characterised in that, the tensile means is incorporated radially centred in the belt, provided with a strip or sheet like tensile means of minimal thickness, and of a width at least substantially corresponding to the width of a contact body disposed on to at least one radial side of said tensile means, effecting a contact between the belt and a drive wheel.
- 10 2. Drive belt according to claim 1, for rotational transfer of a force between two or more drive wheels, provided with a tensile means for transferring the force to be transferred between said drive wheels, and a contact body for realising contact between the belt and the drive wheels, the contact body being composed of a plurality of transverse elements, and between which transverse elements, as taken in the
15 longitudinal direction of the belt, in adhesive contact with the tensile means, is provided an intermediate body of a relatively soft elastically deformable material, characterised in that the tensile means comprises a strap like means of minimal thickness, the width of which strap like means substantially corresponding to the width of the contacting body at the level of the tensile means in the belt, and the strap like
20 means being incorporated in the belt with radial overlapping end parts.
3. Belt according to claim 1, 2 or 3, characterised in that the tensile means is composed of a metal material, preferably spring type metal or of a UD-material.
4. Belt according to any of the preceding claims, characterised in that the tensile means is comprises an elastically deformable, rubber like material, coated on to the
25 tensile element, such that a small layer of material is located in a contact between the tensile element and a transverse element, in particular forming part of the intermediate body.
5. Belt according to any of the preceding claims, characterised in that the tensile element is of a thickness less than 0.5 mm, preferably less than 0,25 mm, in particular
30 0,1 mm or less.
6. Belt according to any of the preceding claims, characterised in that the width of the tensile means at least substantially corresponds to the width of a transverse

element, the width of the transverse element slightly extending beyond the tensile means.

7. Belt according to any of the preceding claims, characterised in that the element thickness is less than 0,20 times the smallest running radius, in particular less than 1,5 mm.

8. Belt according to the preceding claim characterised in that the intermediate body has an elasticity modulus more than 6 times lower than that of the transverse elements.

9. Belt according to any of the preceding claims, characterised in that the mutual distance of the transverse elements corresponds to the thickness of the elements;

10. Belt according to any of the preceding claims, characterised in that the maximum height of the intermediate body corresponds to the mutual distance between the elements.

11. Belt according to any of the preceding claims, characterised in that the intermediate body is provided over at least a substantial part of the width of the tensile means.

12. Belt according to any of the preceding claims, characterised in that the maximum height of the intermediate body is less than half of the transverse element height taken from the relevant radial side of the tensile means to the relevant radial end of the transverse means.

13. Belt according to any of the preceding claims, characterised in that the intermediate body is adhesively attached to the relevant radial face of the tensile means.

14. Belt according to any of the preceding claims, characterised in that the maximum element height is less than half of the nominal element width.

15. Belt according to any of the preceding claims, characterised in that the transverse element is composed of acetals (POM) or high tech thermoplastic or thermoset engineering plastics.

16. Belt according to any of the preceding claims, characterised in that the tensile means is composed of a single part which is curled to an endless element.

17. Endless pull belt, in particular according to any of the preceding claims, more in particular V-belt for application in a transmission with a V-wedged pulley, more in

particular a variable width pulley, comprising a tensile means and transverse elements comprising a V-shape with lateral pulley contacting faces, an elastically deformable spacing means being located longitudinally between said elements, characterised in that tensile means comprises a flat, strip like tensile element of a minimal thickness

5 TT, i.e. $0,05 \text{ mm} \geq TT \leq 0,25 \text{ mm}$, extending over a width WT, substantially matching the nominal width WB of an element, i.e. $0.5 \cdot WB \geq WT \leq 0.9 \cdot WB$, the element being located centred over the radial height of an element in the belt, the tensile element further being composed like a single body, preferably a strip composed of metal material or of a synthetic UD-material.

AMENDED CLAIMS

PCT/IB03/02458

AMENDED CLAIMS

[received by the International Bureau on 23 January 2004 (23.01.04);
original claims 1-17 replaced by new claims 1-21 (3 pages)]

+ STATEMENT

STATEMENT UNDER ART. 19(1) & RULE 46.4 PCT

The present invention at hindsight departs from what has been disclosed by GB 2030 263 (Horrowitz), which document, together with FR 2 515 296 (Bernard) forms the closest prior art.

Horrowitz discloses a CVT belt with a central tensile means; transverse elements for taking up power to be transferred from one pulley to the other; elastically deformable means between the elements and the tensile means. The tensile means is produced in a cord-like manner. Horrowitz teaches adherence of the elastical means to both the tensile means and the transverse means (L. 100 – 104).

The present invention uses a closed, flat, strap like means rather than a bundle of cable like elements. Thus it departs from a common practice that may be noticed since introduction of the elastically means. It thereby teaches away from Bernard. It further teaches away from Horrowitz in that it does not teach an adhesive contact between intermediary means and transverse means.

Bernard teaches to use a metal tensile means in the form of plaited or woven metal fibres, so as to have at least 30% of superficial openings (P. 3 L16) so as to achieve intimate bonding, and to wind several layers of woven fibers spiral wise several times (P2, L6).

The invention provides the advantage and novel insight that by using a flat sheet of tensile means, no risk of cutting of fibres or cables through elastic material is present at all. By using a strip, i.e. a widthwise extending surface, the thickness of the strip is no longer an issue in creating sufficient bonding surface, nor in the risk of the fibres or cables cutting through the elastic means. By said widthwise extending bonding surface, freedom is gained to choose the thickness of the tensile means to be minimal, which reduces the internal tension of the tensile means, thereby increasing the load carrying capacity thereof. Only a single layer of tensile means (possibly having overlapping ends) is required. No surrounding special elastomeric cushion layer as often applied is required.

The relatively older publications (up to 1955) teach a direct mechanical bonding between transverse element and tensile means, whereas more recent documents, i.e. after 1955 teach the use of an intermediary elastomeric means. All recent publications departing from the presence of such intermediate means teach to use cords or the like, or woven or plaited material, apparently with a view to increase bonding with the elastomeric means.

Where in the older publications a strap like means would be applied, e.g. a metal strip, it would either be deformed, e.g. corrugated, or have mechanical connection means such as rivets for mutual bonding.

It is thus concluded that the prior art generally teaches away from the combination of elastically means and a tensile means in the form of a closed strap like means. Moreover, where in remotely related prior art the use of closed straps has been disclosed before, this had not been in the from all respects fully flat manner as taught presently.

PULLING V-BELT

The present invention relates to a pull type belt as defined in the preamble of claim 1.

5 Such belts are generally known in the art, either for application in fixed ratio, or for variable ratio transmissions. Such so called V-belts, simply called "rubber belts", have since long essentially been produced with a body of a natural or synthetic rubber material, and have a reinforcing tensile means in the form of a layer of a plurality of tensile elements such as cords, e.g. produced in a synthetic fibre. Commonly the
10 cords are incorporated in one layer, with the cords lying side by side. The tensile means is embedded in a rubber material. Within the layer, sometimes denoted cushion layer, commonly a specific type of rubber is applied for optimising the bounding between rubber and tensile element.

One limitation of this known type of belt is that the amount of transmissible
15 power, ~~to be transferred from one pulley to another, by a wedging, i.e. clamping action of the sheaves of a pulley,~~ is limited by the amount of power that can be transferred from the rubber to the tensile means. Thus, the force transferable from one pulley to the other is limited by the maximum load of the connection between the rubber and the cords within the belt.

20 Another and major drawback of the known V-belt concerns the smallest running diameter that can be attained at a virtually infinite time of operation of the belt. This phenomenon is especially relevant at V-belts for application in variable ratio transmissions. In these applications it is important to have a sufficiently lateral bearing or contacting surface for contacting the sheaves of a pulley, so as to guarantee a
25 proper and smooth shifting and running feature of the belt. However, this requirement increases the radial height of the conventional V-belt and therewith the bending stress in the belt. Bending stress occurs in a high extend at the radial outer side of a belt. ~~Probably for this reason, the tensile elements of the known, i.e. conventional rubber belt are located closest possible to the radial outer surface of belt.~~ The bending stress
30 also affects the connection between the body and the tensile elements, which connection plays an important role because of a requirement to have a sufficiently large surface area on the tensile elements for bonding, i.e. adhering these to the body material of the belt. ~~The bonding should be such that a meaningful amount of force can be transmitted still during e.g. an industrially meaning full period of operation time~~
35 ~~of the belt.~~

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One solution for reducing internal bending stress commonly applied in commercialised belts is to provide laterally extending, generally V-shaped openings at the radial interior side of the belt. In this way the bending height of the belt is reduced with the radial depth of the openings. Still a relatively high pulley contacting face may be maintained at the rubber bodies between these grooves. Consequently, the bending stress is reduced proportionally with the depth of the groove.

Yet, many commercial applications still require a low cost solution with an even smaller smallest running diameter feature of the belt, e.g. at application in the drive line of scooters, or under the bonnet of a personal vehicle where space is scarce. Scooters have, located near the rear wheel, a relatively bulky transmission case as part of the drive line. The drive line, in particular the bulkiness thereof limits the design freedom of this two wheeled motorised vehicle.

One manner for attaining a very small running diameter of a rubber belt is to design a relatively wide width belt with a plurality of endless V-shaped grooves provided longitudinally to the interior, i.e. the radial inner side of the belt. In this manner a belt of relatively low height, allowing a relatively small smallest running diameter is attained. In this solution the ratio is fixed and the belt is no longer applicable in a variable transmission.

Another disadvantage of the known V belt is that the rubber body required for proper clamping between the sheaves of a pulley is entirely disposed at the radial inner side of the tensile means. Location at the radial outer side of the tensile means could cause the rubber body part to deform, i.e. to bulge out in radial direction, under the clamping action. The deformation may be such that the function of the body is lost at least to a large extent. Bulging out is in conventional V belts a.o. counteracted by a radial outer layer of reinforced material. The clamping body for the belt is consequently situated below the tensile means, i.e. at the radial inner side of the belt. When transmissions with small diameters are sought for, e.g. at limited space applications, this phenomenon reduces the range of transmission ratios that can be attained.

Another high power solution known in the art of pull belts is provided by EP-A-0 826 901. This solution describes a relatively expensive belt of a relatively complicated structure, directed to and particularly suitable for relatively high power transmission systems. The design of this belt features transverse elements, so-called blocks, having a fixed position relative to a tensile means, denoted load carrier. The load carrier consists of two endless parts, each of which is placed into laterally extending slots of the transverse elements. The load carriers each have an rubber like elastically

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deformable material body of noticeable height, in which a centred layer of tensile elements in the form of strings is incorporated. The tensile means and the manner of incorporation correspond to what is known from conventional V-belts, and have the associated draw back of limited transfer of force per unity of width. The transverse elements of this type of belt are produced with have a metal core coated with a synthetic material so as to achieve both a desired amount of axial stiffness and a required amount of friction with the sheaves of a pulley. This design renders a relatively complicated manufacture. Also, the body of the load carriers or tensile means show a relatively complicated profiled shape, different at the radial inner and the radial outer surface, and matching the profiling of the lateral slots of the transverse elements. After the driving force has been transmitted from the sheaves to the transverse elements, the latter carry this force over to the tensile bodies by said a different upper and lower profiling therein. Subsequently the force is conducted from the body of the load carrier to the layer of cords in the conventional manner. The profiling of the elements and of load carrier per se, each with two shapes, may disadvantageously form an additional drawback at manufacture of the belt.

Yet another proposal for improvement of the conventional V-belt solution is provided by US 4,915,677. The publication discloses a pull belt with one or a plurality of a so-called tension resistant members, embodied by a layer of cables. This known pull belt is preferably provided with metal transverse elements preferably of a metal material which are opened to the radial outer side by a recess. The bottom side of the recess is profiled for receiving a plurality of cables disposed in a layer at a level in the upper, i.e. radial outer, half of the elements. For the sake of improvement of the force distribution in the element, a filler element is present, filling the recess and aiding in the bonding between the cables and the elements. The bonding is enhanced by an elastomeric mass joining the transverse elements and the tension resistant member. Thus, also the This design proposed by this document suffers from the drawback of the conventional V-belt, in that the transmittable force is limited by the force transmittable from the elastomeric body to the cables incorporated therein. Moreover fabrication, i.e. manufacture is also complicated by the requirement of precisely receiving the cables in the relevant recesses between the element and the filler. A disadvantage exists in that the pulley contacting limbs tend to deflect inwardly under high pressure, so that insufficient clamping force is taken up by the element as a whole. It was suggested to fill up the recess for receiving the tensile means, i.e. the space between the limbs by a filler plate, preferably to be welded between and against said limbs. This solution

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complicates the design of the belt and raises production costs. The belt according to this solution was dimensioned to accommodate relatively large power transmissions.

The present invention thus seeks to improve the pull belt type for variable transmissions in such a manner that a relatively small smallest running diameter can be attained at application in a transmission, in particular a continuous variable transmission, without undue sacrifice to durability, i.e. life span of the belt, nor to force transmittable by the belt, and without undue complication of the design and manufacture of the belt. In particular the invention aims to provide a design technically and economically applicable and without undue manufacturing efforts, more in particular in the area of relatively small power transmissions like at the conventional rubber V-belt designs.

According to the invention, such is attained by the characterising portion of claim 1. The ultimately thin tensile element as featured in the design according to the invention effects a very low bending stress in the tensile element, thus enables a relatively long life time of the belt, or very small smallest running diameter of the belt at equal life time. This feature of the invention is made possible by a measure to extending the tensile element over a broadest possible width, i.e. possibly as broad as the belt or any element incorporated therein, however without contacting the sheaves of the pulley. In practice good results may be achieved with the width being from 0.5 up to 1 times the width of the belt or, if transverse elements are incorporated in the belt, from 0,5 to 0,9 times the width of the element at the effective running diameter of the belt. The tensile element is according to the invention preferably located central to the radial height of the belt. By this measure according to the invention, the tensile stress within the tensile means is reduced to a minimum, specifically since it is combined with the feature of being a thin bladed means, i.e. having radial thickness of minimal amount.

By the above said features a belt according to the invention may in a first embodiment be used favourably both as a replacement of V-belts having a plurality of longitudinal grooves, since it requires only a small amount, in a flat layer of elastically deformable material, preferably at each side of the tensile means for creating a comparable amount of friction surface, while it may be bend easily over even smaller diameters and with equal contacting features at both radial sides of the belt.

The belt according to the invention may in a further elaboration also favourably be applied as a replacement of the tensile means as used in an arrangement like EP-

A-0826901 by adopting the appropriate profiling for the elements thereof. With a belt

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according to the present invention, the said V-belt arrangement may adopt even smaller running diameters, smaller pitch distances and higher power throughput.

In a third embodiment of the invention ~~the new belt~~ is produced suitable for a continuous variable transmission by the provision of transverse means having a centre opening through which the tensile means is passed, and with an elastically deformable material located longitudinally in between the transverse means, and having an adhesive connection with a radial surface of the tensile means.

~~In the above embodiments of the invention, a double layer of ultra thin material, is favourably applied, of which according to the invention radial facing sides are mutually connected, either mechanically or by an ultra thin layer of gluing material such as metal glue, an ending piece of strap is made endless. This is according to the invention most favourably performed when at least virtually the entire longitudinal length of so created endless means is provided with a double layer. Preferably however, a minimal overlapping part of three layers is created, e.g. up to 5% of the longitudinal length. In case the belt according to the invention is provided with transverse elements according to the invention, no in between glue is required, since use is favourably made of an intermediate elastically material adhered to both radial sides of a combined layer of tensile means, preventing the tensile means from being pulled to a loose assembly, forming a particular embodiment of mechanical connection between end parts of a single strap element.~~

The invention may also be characterised as a tensile belt where elasticity and stiffness requirements of the different subcomponents are split up in such a way that they are optimal for the requirement of that component. This leads to a tensile belt that is suitable for very small running radii and which has minimal internal losses leading to a high efficiency belt and low operating temperatures, which is specially important for belts that are partially or completely composed of polymers and/or elastomers.

In the current belt, transverse elements that are stiff enough to prevent deformation of the belt between the pulleys, reducing internal friction losses and forming a beam to resist the required clamping force of the pulley sheaves. These elements may favourably relatively easily be provided with a relatively high resistance to wear. The belt further includes spacing means of an elastic material with negligibly modules of elasticity to eliminate bending stresses in the belt and with a good bonding performance with the radial surface of e.g. a metal strap like tensile means. Thus a good transport of driving force from the tensile element to the transverse elements or vice versa is made possible. The spacing means is in this arrangement compression

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loaded by the force transfer between tensile element and transverse element and vice versa, preventing peel of the bonding layer between spacing means and tensile element.

- 5 ~~When a double layer of tensile sheet element is used, according to a specific embodiment of the invention, a heavy duty metal grease is used between them, while the sides are being sealed with a same elastomere as for the spacing means, leading to wear reduction between the layers.~~

The invention will now be elucidated further according to a drawing in which:

FIGURE 1A to 1C relate to conventional rubber V-belts;

- 10 ~~FIGURE 2 is a first embodiment of the V-belt according to the invention, with transverse elements mechanically coupled to a tensile means;~~

~~FIGURE 3 is a first alternative embodiment of a V-belt according to the invention;~~

~~FIGURE 42 is a perspective view of second and preferred alternative an~~
embodiment of the V-belt according to the invention;

- 15 ~~FIGURE 53 is an illustration of different techniques according to the invention for realising an endless tensile means within the belt;~~

~~FIGURE 64 schematically shows an alternative and preferred embodiment of the tensile means, i.e. consisting of two layers;~~

- 20 ~~Figure 74 illustrates an advantage of the belt according to the invention when applied as a replacement belt for a conventional belt;~~

Figure 85 illustrates a preferred shape of the transverse elements;

~~Figure 9 by sectional views of different transverse elements, illustrates possible shapes of a transverse element according to the invention;~~

- 25 ~~FIGURE 106 illustrates a common manner of operating a conventional rubber V-shaped belt in a continuously variable transmission;~~

FIGURE 117 illustrates the possible reduction in dimension of a transmission or variator when the belt according to the invention is applied instead of a conventional belt.

- 30 The following description departs from the overall shapes and elements of a V-belt and of the associated and mentioned manufacturing processes as commonly known per se. The invention is primarily found in the new design of the belt. Secondly the order and manner of assembling the separate components in the belt according to the invention are mentioned.

- 35 In figure 1, three conventional rubber belt types are represented, a first one suited for transmissions having a fixed transmission ration. A second one typically

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adapted for variable ratio transmissions, and a third one typically adapted for uses with small running diameters, however, only suitable for a fixed ratio transmission.

In figure 1A the conventional rubber V-belt 1 for fixed ratio transmission is shown with an outer coating 2 all around the belt 1. It has a rubber body 5 of soft elastic nature, and a thin outer coating of a relatively hard elastic nature, however providing resistance to wear. Embedded in an embedding layer 3 of material specifically suitable for connecting to a tensile means 4. The tensile means 4 consists of a layer of relatively thin rope, e.g. a Kevlar material, wound equally distributed over the width of the belt. The radial thick body 5 prevents the belt from adopting small running diameters, however promotes a stable running of the belt in the V-groove between the sheaves of a pulley.

The belt according to figure 1B is modified in that no surrounding is outer body is provided, in that the body is of a stiffer rubber type and is at the radial inner side provided with transverse grooves, commonly distributed at even distances of between 0.8 and 1.5 cm. At the radial outer face, a reinforced layer of relatively stiff material 6 is provided, supporting the stiffness of the belt in axial direction, thereby enhancing the efficiency of the belt.

The belt according to figure 1C is provided with V-shaped grooves 8 extending in longitudinal direction, thereby increasing, i.e. regaining contacting area with correspondingly grooved fixed ratio pulleys of a small running diameters. No outer support layer 6 is required since the belt is not loaded with axial thrust originating from sheaves of a pulley.

~~Figure 2 represents a first principal modification of the V-type pull belt in accordance with an idea underlying the invention. It The invention shows a separation in function of a transverse clamping means 13 and a tensile loadable body 11, in casu embodied by a flat strip of a tensile loadable material, preferably spring type steel or a synthetic tape of a synthetic uni directional (UD-) material. A transverse element 13 is mechanically coupled to the tensile body 11, in casu by a pop nail construction known per se, wherein the nail is part of the transverse element. Internally it shows a U-shape, of which the bottom part forms a contacting face for contacting the tensile body. It is of a width matching that of the tensile body. The contacting face is centrally provided with a nail part. The transverse element may be composed of metal but is preferably entirely composed of a synthetic material. The nail part is inserted through an opening in the tensile body, and subsequently popped, either mechanically in case of a metal nail or thermo-mechanically in case of a synthetic material.~~

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The strip 11 forming the tensile body 11 according to the invention, composed of metal like spring steel or of unidirectional synthetic tape ("UD-tape"), is of a thickness considerably smaller than that of the cords 4 applied in conventional tensile bodies. Typically the reduction in thickness is of a factor between 5 and 10 times the conventional thickness. According to the invention the metal or synthetic strip 11 applied is of a thickness between 0.04 and 0,25 mm, more preferably up to 0,1 mm, compared to conventional cord thickness of between 0.6 and 1.2 mm. This measure in accordance with the invention effects a considerable reduction of bending stress within the tensile body 11, implying a longer life time when a belt 10 with such tensile element 11 is run at a corresponding running radius, or an equal life time at a considerably smaller running radius.

The immense reduction in thickness of the tensile element 11 is in accordance with the invention made possible through the fact that the tensile element 11 is produced strip like, i.e. entirely flat. By this feature, compared to conventional layers of cord 4, the required small amount of space between the cords 4 is entirely occupied in width wise, i.e. lateral and axial direction. Very importantly, by this design of the tensile element 11, very high contacting pressures between tensile body or element 11 may be realised since a danger of the cords 4 cutting through the body of the transverse elements 13 or of an additional layer within the tensile body is strongly if not entirely taken away. In the present design, the transverse element 13 and the tensile body 11 mutually engage for driving action mechanically, ~~both by said inserted nail and by a frictional contact between contacting face and the tensile body.~~

Another characterising feature of a design in accordance with the invention, is that the tensile body 11 is located centred in radial direction relative to the radial height of the contacting faces 14 of the transverse elements 13, thus further reducing the tensile load and stress on the tensile element 11 in the belt 10. In the present embodiment where the tensile body 11 is solely formed by a tensile strip 11, and where the thickness of the strip 11 may virtually be neglected, this implies that the effective point of contact or location of the friction force of a contacting face 14 is located virtually centred relative to the radial height of the contacting faces 14 of the element 13.

~~Figure 3 represents an alternative construction for the belt according to figure 2, in which the tensile body is provided with lateral ear parts or in reversed sense, with slot like openings. The openings show axial contacting rims by which the tensile body is contacted. The openings have a longitudinal depth fitting the thickness of a~~

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~~transverse element, at least the limb part thereof. The total width of the tensile body is less than the local width of the transverse elements, so as to prevent the tensile body from contacting the sheaves of the pulley. The axial width of the slotted opening substantially corresponds to the local width of the limbs of the transverse elements.~~

- 5 ~~Preferably the openings are created by bending the material originally present in the slot area in downward or upward direction, according to an axial folding line coinciding with an axial contacting rim for contacting a transverse element. The drawing, the transverse element may be provided with retractable limb parts for keeping the tensile element in place. Overlapping ends of the tensile element are fixed in longitudinal~~
- 10 ~~direction via said ear parts~~

The tensile body 11 may also be produced as a tensile strip 11 coated with an elastically deformable material 12 such as vulcanised rubber or a synthetic rubber material. The presence of the elastic material 12 in this context assists in levelling local pressure peaks, thus enhances lifetime of the belt.

- 15 In the embodiments according to figures 42 advantage is taken of the circumstance that in accordance with the invention it is relied on the shear force feature of the elastically deformable material of the intermediate body 12, rather than on the tensile force coefficient of this material, implying that a relatively high tensile force can be carried over in the tensile means 11. ~~For the latter reason a V-belt~~
- 20 ~~according to the invention may be embodied with a relatively small, i.e. thin layer of elastic material between the ends of the tensile element.~~

- Figure 42 schematically depicts the structure of an embodiment according to the invention in which connection between the tensile element 11 and the transverse element 13 is realised through an elastically deformable material 12, firmly bonded, i.e.
- 25 adhesively connected to the strip element 11, e.g. glued or otherwise bonded, with the material preferably extending over the width of the strip 11. In the embodiment according to figure 42, first the elements 13 are shifted over the tensile element 11 after which the elastic material 12 is applied. According to an alternative embodiment of a manufacturing process, the tensile element is first coated with the elastic material
- 30 after which the transverse elements are shaped with an injection moulding machine. In both embodiments for a manufacturing process ~~the~~ The tensile body 11, 12 consists of a mirrored profiling at each of both radial inner and outer surface face of the tensile means 11. The elastic material 12 is at least present longitudinally in between two adjacent transverse elements 13 and is firmly connected to the strip element 11, i.e. it
- 35 has an adhesive bonding, either or not enhanced by mechanical or chemical treatment

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of the radial surface area of the tensile means 11. It has a very high resistance against shear and peeling, alternatively denoted a high coefficient of adhesion. Preferably vulcanised rubber is used for this purpose, however, also a combination of dedicated surface treatment and a subsequent application of synthetic rubber showed useful results.

The transverse element 13 in these embodiments extends two sided over the tensile body 11, thus shows a centralised slotted opening 15 fitting a cross section of the tensile body 11. In accordance with the invention, the elements 13 are moulded in location around the tensile means. ~~Equally however, the transverse elements may be cut out of a piece of suitable material, or may be individually (injection) moulded and subsequently be tacked or stringed to the tensile strip 11, brought into mutually correct position by means of a mall. In case of moulded elements 13, a distance boss 16 is provided to the elements 13. Subsequently the elastic material 12 is provided by injection or transverse moulding, intermediate to the transverse elements 13.~~

Application of the intermediate elastic material 12 in the embodiment according to figure 4 can e.g. be done by one or more injection nozzles directed to the surface of the tensile strip 11. At each embodiment, the elastic material 12 is provided over a thickness of more than 1 mm above the strip surface and preferably at a maximum of half or less than a quarter of the total radial height of the contact face 14 of a transverse element. However, the gap between transverse elements 13 may without undue influence to the basic function of the belt also be filled entirely.

Preferably the central opening 15 in the transverse element 13 shows a rounding 17 or a chamfer 17 of the edges as seen in radial and – belt wise – longitudinal cross section. In this manner both the tacking of the elements 13 over the strip 11 is enhanced by the presence of a funnel like entry of the opening 18. Also, the contact between the element 13 and the elastic material 12 is optimised. Further it is realised that any damaging contact between element 13 and tensile strip 11, likely to be caused by a high surface pressure due to sharp edges at the element 13 is minimised. The latter shape of the element slot 15 according to the invention, at driving activation of a transverse element 13 by the sheaves of a pulley, urges the element 13 on to the intermediate material 12. By the chamfer 17 or otherwise manner of rounding, a funnel-like opening 18 is created at the central opening 15 of the element. The elastic material between two transverse elements 13, by the funnel shape 18, tends to become gradually compressed towards the surface of the tensile strip 11 under the influence of any longitudinal driving force of a transverse element 13, thus causing the

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internal friction capacity of the elastic material 12 and the friction with the strip surface to be increased, optimising the transfer of driving power from the transverse element 13 to the tensile strip.

5 ~~Figure 8-4 and 9~~ shows ~~an~~ examples of such above described funnelled openings 18, in casu with a rounded, ~~respectively chamfered~~ opening. Due to subsequent injection of the intermediate material 12, the latter adopts the shape created in the opening 18 of the element 13.

10 ~~In the embodiment according to figure 4, the belt according to the invention may be produced by coating the strip element first, with a rubber or synthetic rubber like material, preferably in a profiling matching the above described chamfer or rounding, preferably symmetrically at both radial sides of the tensile body, and subsequently moulding the transverse elements in place, using a suitable mall for maintaining the tensile body in a desired position and shaping the transverse elements.~~

15 In accordance with the invention the transverse elements 13 are produced of a very stiff, i.e. non-compressible synthetic material, preferably fibre reinforced, having a high temperature resistance, i.e. preferably over 100 or even up to 150 degrees Celsius, and with a reasonable coefficient of friction in combination with metal sheaves. One such material is of the acetal group (POM). Any alternative matching such criteria, such as high tech thermosets like phenol based materials or high tech engineering plastics with or without fibre filling may equally be applied however. 20 Although a metal transverse element 13 could be used, the invention applies a synthetic material so as to more easily provide the elements 13 with the desired shape details, and so as to enhance manufacturing of the elements and equally to enhance assembly of the belt 10 according to the invention.

25 Figure 53 illustrates several manners of realising an endless tensile means 11 produced in a single layer effectively. The upper manner simply shows two end parts 20 of a tensile means 11 overlapping radially. A mechanical stopping means 21, 22 may be provided according to the invention, either by bending an end part 21 of the tensile means 11 transverse to the longitudinal direction, or by locating a rim 22 on a 30 radial face, e.g. a soldered rim.

~~Figure 64 in accordance with the invention shows a preferred manner of incorporating a tensile element in the new V-belt. In this shown embodiment the tensile means is produced in two layers. In the embodiment shown the tensile means consists of two parts. Preferably, though not depicted, the tensile means is produced of one 35 piece, with the ends overlapping to a small extent. In both embodiments the ends are~~

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mutually interconnected via the transverse elements. Additional mechanical connections may be used, e.g. via the intermediate elastically deformable means. In this manner the tensile element is virtually made endless. The thickness of the element is in this case taken half the thickness required for transferring a force in the
5 embodiment with one layer effectively.

Figure 75 shows a further advantage of the present invention ~~which invention,~~ which is most favourably used when the current belt 10 is applied as a replacement belt for a conventional rubber belt, i.e. in a variator of otherwise conventional dimension. Since the tensile means 11 is located radially centred, the driving force of
10 the transmission is effectively located at radial lower point of up to 5 mm. This phenomenon is of a relative high significance at the smallest diameter, compared to the situation at the other driving wheel where the largest running diameter occurs at such instance. Thus in the initial stage of transmission, an improved so called launch performance, e.g. at scooters is achieved.

Figure 85 in detail shows a preferred embodiment of a transverse element 13, with distance bosses 16 for mutually easily positioning the elements when strung on a tensile element 11. The bosses 16 are located at the radial level of the tensile means 11. By the cross section on the right hand side of the figure, the rounded contact face of the elements for contacting the tensile means is shown, creating the earlier
20 described, and favourable funnel shape. However, as illustrated by the comparable cross sections in figure 9, different shapes be chosen, including a triangular wedge shape and a simple slotted opening.

Advantages of the belt 10 according to the invention include the reduced smallest possible running diameter, and the small, material saving transmission case
25 consequently required, an increased efficiency of the belt due to reduction of internal losses otherwise caused by compression, both in longitudinal and in axial direction, and an increased life time of the belt due to the use of reinforced, non-compressible synthetic material in the transverse elements, and to the reduced tensile stress in the tensile element, due to it's strongly reduced thickness. Moreover, the belt according to
30 the invention may realise a significantly increased transfer of power due to the lower position of the tensile element as compared to conventional rubber V-belts.

Figure 406 and 417 together provide an indication of the effects attainable with a belt 10 according to the present invention. In Figure 406, schematically part of transmission line of a scooter is shown with the contour of a pulley sheave to the front
35 side at the left hand side of the figure and one to the rear side at the right hand side in

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the figure. At the front side the smallest possible running diameter is utilised since the take off or launching of a vehicle is only short lived. At the rear wheel however, the smallest running diameter, occurring in overdrive (OD) situation occurs most of the operation time of the vehicle. So as to enhance life time of the belt, the smallest running diameter is commonly limited to a diameter about twice that of the smallest diameter at the front pulley. With a belt 10 designed in accordance with the invention, such limitation may be omitted. Moreover the smallest possible running diameter is even further reduced, so that for achieving a comparable transmission ratio, the diameter of the pulleys may be reduced.

10 Figure 41-7 shows that the overall length of a transmission drive line may be significantly reduced. This may amount from about 75% of the smallest possible distance D2 between the axes of two conventional pulleys up to almost 50% of the currently applied space D1 between the pulleys of nowadays scooters. Thus the invention also relates to a scooter or alike vehicle, having a variator, with a belt 10 according to the invention, and integrated with the engine, i.e. incorporated within the dimensions thereof, and having a fixed ratio transmission, e.g. by a belt between the variator and the rear wheel.

20 When a belt 10 according to the invention is merely applied as a replacement belt, i.e. with a conventional dimensioning of the variator, still a significant advantage exists in a structurally higher potential of transferring power due to the low position of the tensile element 11. It may a.o. be used to enhance the driving characteristic of such vehicle in the LOW driving mode. For instance, the coupling may be tuned to close somewhat earlier, so that a driving force may already be transferred at lower engine speed, due to the enhanced torque transmission capacity in combination with a belt 10 according to the invention.

25 The invention apart from the preceding description and all details of the drawing in particular relates to the following set of claims.

AMENDED CLAIMS

[received by the International Bureau on 23 January 2004 (23.01.04);
original claims 1-17 replaced by new claims 1-21 (3 pages)]

+ STATEMENT

1. Drive belt (10) ~~(10)~~ for rotational transfer of a force between two or more drive wheels, provided with a tensile means (11) for transferring the force to be transferred
- 5 between said drive wheels, in which the tensile means (11) is incorporated radially centred in the belt, which belt is provided with transverse elements (13) ^{each} disposed on to ~~at least one~~ radial side ^{of} said tensile means (11), effecting a contact between the belt (10) and a drive wheel, and in which ^{elastically} deformable material ~~(12)~~ is included
- ^{unctionally} between the tensile means (11) and the transverse elements (13), characterised in
- 10 that the tensile means (11) is ^{safety} composed of a flat strip or sheet like tensile means of minimal thickness, and of a width at least substantially corresponding to the ^{local} width of a transverse means (13), *

* which transverse elements are each provided with a slotted opening for receiving the tensile means (11),

* an intermediate body (12) of

F. effecting a transfer of driving power from the elements (13) to the tensile means (11) and vice versa

* in which the intermediate body (12) has an adhesive connection with a radial face of the tensile means, in which the slotted openings of the transverse elements fit a cross section of the tensile means (11), ^{in which} and the intermediate body (12) is located ^{physically} longitudinally in between two transverse elements.

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AMENDED CLAIMS

[received by the International Bureau on 23 January 2004 (23.01.04);
original claims 1-17 replaced by new claims 1-21 (3 pages)]

+ STATEMENT

1. ~~Drive belt (10) for rotational transfer of a force between two or more drive wheels, provided with a tensile means (11) for transferring the force to be transferred between, said drive wheels, in which the tensile means (11) is incorporated radially centred in the belt, which belt is provided with transverse elements (13) disposed on to at least one radial side of said tensile means (11), effecting a contact between the belt (10) and a drive wheel, and in which elastically deformable material (12) is included between the tensile means (11) and the transverse elements (13), characterised in that the tensile means (11) is composed of a flat strip or sheet like tensile means of minimal thickness, and of a width at least substantially corresponding to the width of a transverse means (13).~~
2. Belt (10) according to claim 1 characterised in that the tensile means (11) is included in the belt (10) with overlapping end parts (20); *and the intermediate body (12) is disposed at each radial face of the tensile means (11).*
3. ~~Belt (10) according to claim 1 or 2, characterised in that the width of which strap like means (11) substantially corresponding to the width of the transverse means (13) at the level of the tensile means in the belt (10), and in that the strap like means (11) is incorporated in the belt (10) with radial overlapping end parts (20).~~
- 3.4. Belt (10) according to claim 1, ² ~~2~~ or ~~3~~, characterised in that the tensile element (11) is composed of a metal material, preferably spring type metal or of a ^{synthetic (uni-directional)} UD-material.
- 4.5. Belt (10) according to any of the preceding claims, characterised in that the tensile means (11) comprises an elastically deformable, rubber like material (12), coated on to the tensile element (11), such that a small layer of material (12) is located in a contact between the tensile element (11) and a transverse element (13).
- 5.6. Belt (10) according to any of the preceding claims, characterised in that the tensile element (11) is of a thickness less than 0.5 mm, preferably less than 0,25 mm, in particular 0,1 mm or less.
6. Belt (10) according to any of the preceding claims, characterised in that the width of the tensile means (11, 12) at least substantially corresponds to the width of a transverse element (13), the width of the transverse element (13) slightly extending beyond the tensile means (11, 12).

7 ~~8~~. Belt (10) according to any of the preceding claims, characterised in that the element (13) thickness is less than 0,20 times the smallest running radius, in particular less than 1,5 mm.

8 ~~9~~. Belt (10) according to the preceding claim characterised in that the elastical
5 deformable material (12) has an elasticity modulus more than 6 times lower than that of the transverse elements (13).

~~9 10. Belt (10) according to any of the preceding claims, characterised in that the mutual distance of the transverse elements (13) corresponds to the thickness of the elements (13).~~

10 ~~9 11~~. Belt (10) according to any of the preceding claims, characterised in that the maximum height of the intermediate body (12) corresponds to the mutual distance between the elements (13).

10 ~~12~~. Belt (10) according to any of the preceding claims, characterised in that the intermediate body (12) is provided over at least a substantial part of the width of the
15 tensile means (11).

11 ~~13~~. Belt (10) according to any of the preceding claims, characterised in that the maximum height of the intermediate body (12) is less than half of the transverse element height taken from the relevant radial side of the tensile means (11, 12) to the relevant radial end of the transverse means.

20 ~~14~~. ~~Belt (10) according to any of the preceding claims, characterised in that the intermediate body (12) is adhesively attached to the relevant radial face of the tensile means (11).~~

12 ~~15~~. Belt (10) according to any of the preceding claims, characterised in that the maximum element (13) height is less than half of the nominal element width.

25 ~~13~~ ~~16~~. Belt (10) according to any of the preceding claims, characterised in that the transverse element (13) is composed of acetals (POM) or high tech thermoplastic or theroset engineering plastics.

14 ~~17~~. Belt (10) according to any of the preceding claims, characterised in that the tensile means (11) is composed of a single part which is curled to an endless element.

30 ~~15~~ ~~18~~. Endless pull belt, in particular according to any of the preceding claims, more in particular V-belt for application in a transmission with a V-wedged pulley, more in particular a variable width pulley, comprising a tensile means (11, 12) and transverse

- elements (13) comprising a V-shape with lateral pulley contacting faces, an elastically deformable spacing means (12) being located longitudinally between said elements (13), characterised in that tensile means (11, 12) comprises a flat, strip like tensile element (11) of a minimal thickness TT, i.e. $0,05 \text{ mm} \geq TT \leq 0,25 \text{ mm}$, extending
- 5 over a width WT, substantially matching the nominal width WB of an element (13), i.e. $0,5 \times \text{WB} \geq WT \leq 0,9 \times \text{WB}$, ~~the tensile element (11) being located centred over the radial height of a transverse element (13) in the belt (10)~~, the tensile element (11) further being composed like a single body, preferably a strip composed of metal material or of a synthetic UD ~~material~~ *(uni-directional) material*.
- 10 18. Belt according to any of the preceding claims, characterised in that an opening (15) in the transverse element ⁽¹³⁾ for receiving the tensile element (11) comprises a funnel like shaped entry.
- 17 20. Belt according to any of the preceding claims, characterised in that an opening (15) in the transverse element ⁽¹³⁾ for receiving the tensile element (11) is located
- 15 centralised in the element (13).
- 18 21. Belt according to any of the preceding claims, characterised in that the transverse element (13) comprises distance bosses (16).
- 19 Belt according to any of the preceding claims, characterised in that the elastically deformable material (12) extends radially from a surface face of the flat strip to form a cone shaped apex between the adjacent transverse elements (13).

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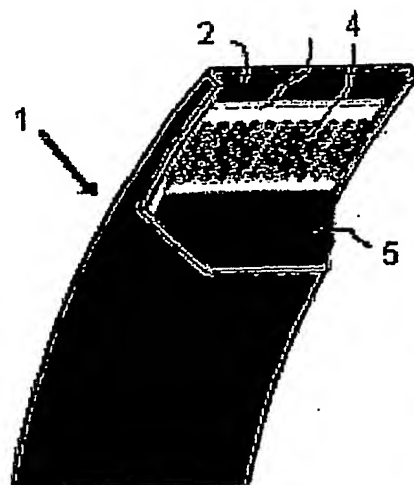


FIG. 1A

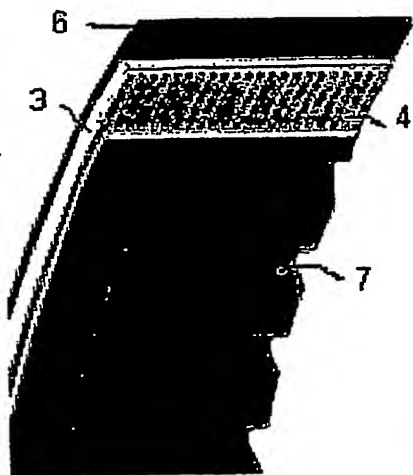


FIG. 1B

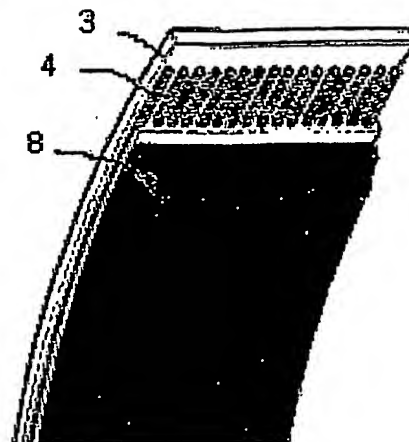


FIG. 1C

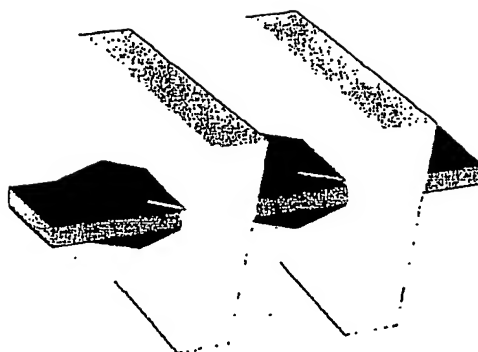


FIG. 2

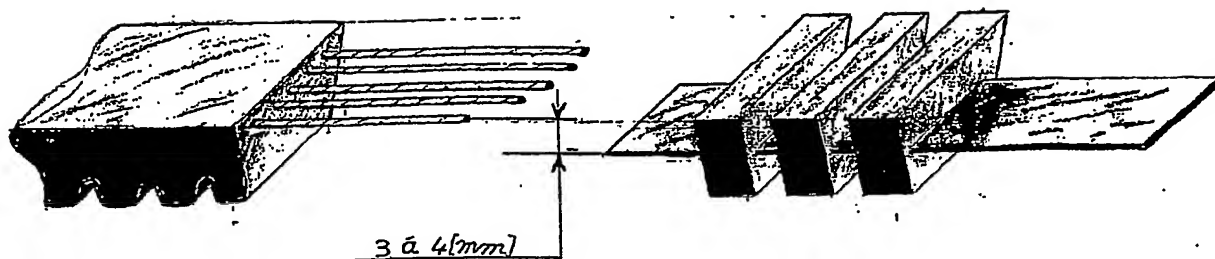


FIG. 5

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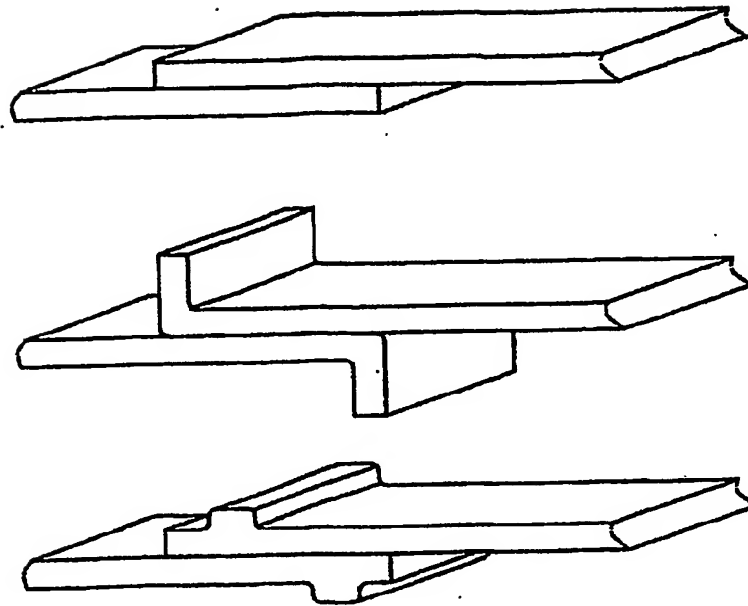


FIG. 3

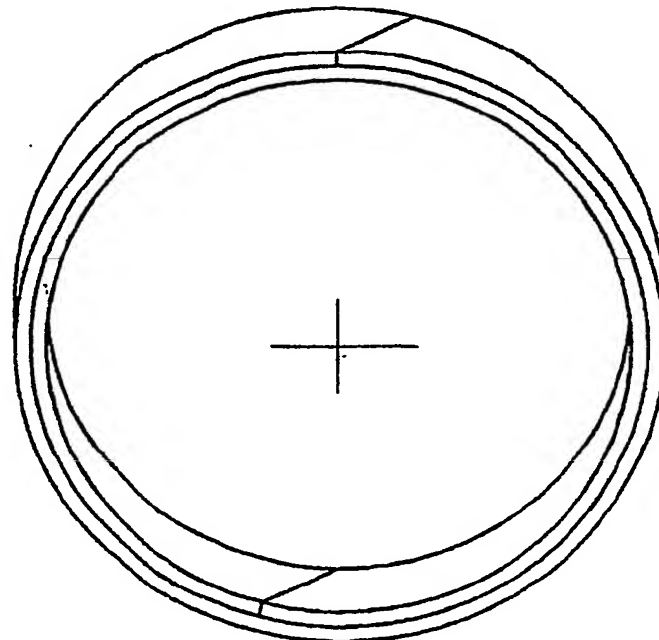


FIG. 4

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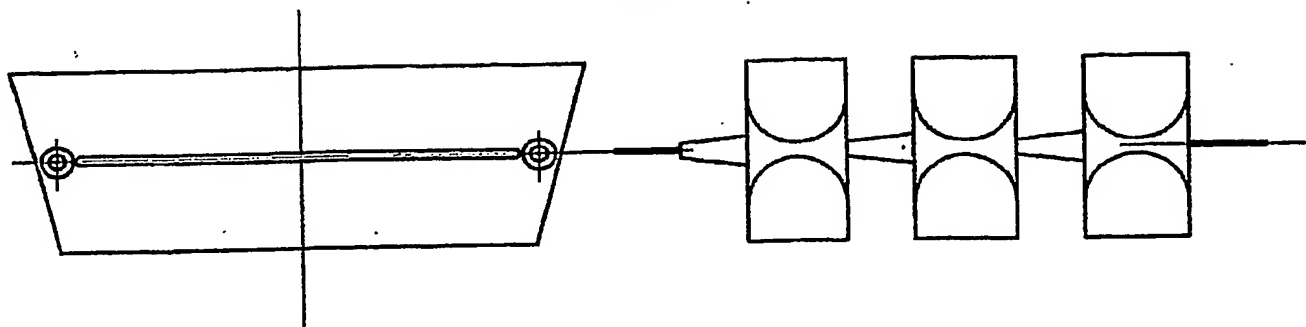


FIG. 6

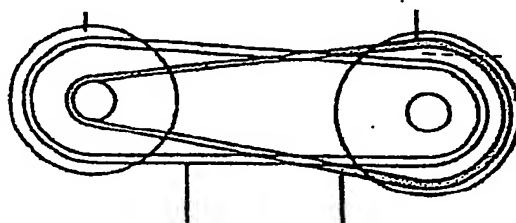


FIG. 7

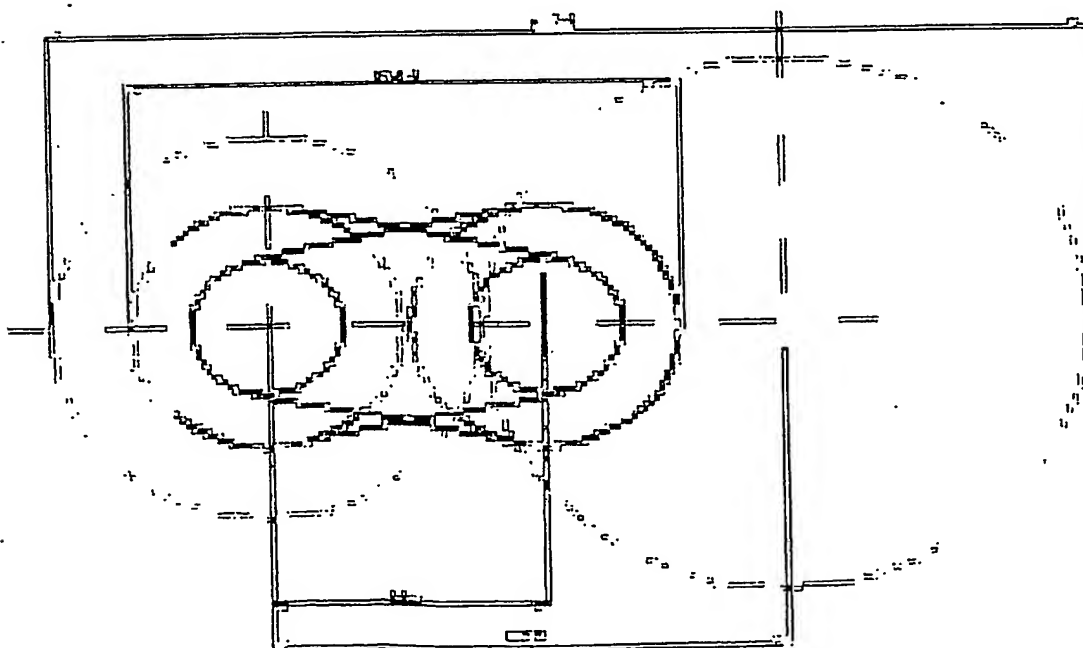


FIG. 8